ER 80S-B2 (A32)

Low Alloy **WIRE/GTAW**

Standards

EN/ISO-Standard - 21952-B
EN/ISO-Classification - 1CM

AWS-Standard - A5.28
AWS-Classification - ER 80S-B2

Features and Applications

- Low alloy copper coated wire with 1.25% Cr and 1% Mo content used for the welding of heat-resistant steels.

- Suitable for welding 0.9% Cr and 0.5% Mo steels.

- Designed for high temperature power generation applications.

- Recommended working temperatures of up to 550°C.

- Typically used on equipment for the chemical and ammonia synthesis process, heat exchangers, boilers, pipes, pressure vessels, petrochemical industries etc.

- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.

- **Test Certificates can be found online @wilkinsonstar247.com**

GREEN WIRE

Typical Base Materials

13CrMo4-5, G17CrMo55, A387:2,11,12, A200: T11, T12, GS 25CrMo4, GS 18CrMo910, 10CrMo910, 10CrSiMoV7, 10CrV63, 12CrSiMo8*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Mechanical Properties (Typical)

Tensile Strength (N/mm²)	Yield Strength (N/mm²)	Elongation (%)	Impact Strength (J)	Test Temperature
620	510	24	100	-10°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu %ᵃ	Cr %	Ni %	Mo %	Al %	V %	Fx ppm
0.08	0.55	0.60	<0.012	<0.015	<0.25	1.30	<0.20	0.50	<0.020	<0.010	<15

ᵃ (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300324	1.00	1000	5	Cardboard Tube
3010300325	1.20	1000	5	Cardboard Tube
3010300326	1.60	1000	5	Cardboard Tube
3010300328	2.40	1000	5	Cardboard Tube
3010300329	3.20	1000	5	Cardboard Tube

Made in Italy

WELD STAR®