

T-80SB2

AWS ER80S-B2
DIN SG CrMo1
JIS YGT1CM

FOR HEAT-
RESISTING STEEL

Typical applications

1.25%Cr-0.5%Mo Heat Resistant steels.

Characteristics on Usage

- ① Ar Gas is mainly used for the shielding
- ② Excellent mechanical and toughness properties after PWHT.
- ③ Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- ④ Preheat at 100°C to 200°C and post weld heat treatment at 620°C to 720°C is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

Typical chemical composition of rod (%)

C	Si	Mn	Cr	Mo
0.09	0.54	0.51	1.26	0.45

Typical mechanical properties of all-weld-metal

Y · P	T · S	El	Charpy V-notch
N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)	J {kgf · m} (0°C)
500 {51}	590 {60}	26	80 {80}

Approved by