



# CEWELD SA 80S-B8

|                                                   |                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |     |          |    |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-----|----------|----|
| TYPE                                              | Medium alloyed, high-strength 9% Cromium alloy SAW wire.                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |     |          |    |
| TOEPASSINGEN                                      | Low alloyed copper-coated SAW wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petrol-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to ~600°C. |                         |                      |                    |                         |     |          |    |
| EIGENSCHAPPEN                                     | The 9%Cr-1%Mo creep resistant alloy is used for service up to ~600°C particularly in environments involving hot hydrogen gas. Flux CEWELD® FL 880                                                                                                                                                                                       |                         |                      |                    |                         |     |          |    |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                     | A 5.23: EB8             |                      |                    |                         |     |          |    |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                  | 24598-A: S CrMo9        |                      |                    |                         |     |          |    |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                    | 6                       |                      |                    |                         |     |          |    |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                      | 4                       |                      |                    |                         |     |          |    |
| GESCHIKT VOOR                                     | ASTM: A 182 Gr F9, A 199 Gr T9 , A 213 Gr T9 , A 217 Gr C12 , A 234 Gr WP9, A 335 Gr 9 , A 336 Gr F9 , A 387 Gr 9 , EN (BS 3100 Gr B6), (BS 3604 Gr CFS 629-470, HFS 629-470), (BS 3604 Gr HFS 629-590, CFS 629-590) , (DIN GS-12CrCrMo 10-1) , (DIN X12CrMo 9-1) , (DIN X7CrMo 9-1) W.Nr: 1.7386, 1.7388, 1.7389                       |                         |                      |                    |                         |     |          |    |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |     |          |    |
| LASPOSITIES                                       | <div>  </div>                                                                        |                         |                      |                    |                         |     |          |    |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                       | Si                      | Mn                   | P                  | S                       | Cr  | Ni       | Mo |
|                                                   | 0.08                                                                                                                                                                                                                                                                                                                                    | 0.4                     | 0.6                  | 0.01               | 0.01                    | 8.7 | 0.18     | 1  |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                          | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |     | Hardness |    |
|                                                   |                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    | RT                      |     |          |    |
|                                                   | 730°C- 760°C 1h                                                                                                                                                                                                                                                                                                                         | 540                     | 660                  | 19                 | 55                      |     | HRc      |    |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                            |                         |                      |                    |                         |     |          |    |
| GAS ACC. EN ISO 14175                             |                                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |     |          |    |



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SA 80S-B8 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| B-450     | 25      | 8720663416995 |