

AK ER80S-B2

Description: ER80S-B2 is for gas metal arc welding of 1¼ chromium, ½ molybdenum steels, which are used in high temperature applications. 300°F min. preheat and inter-pass are recommended during the welding operation.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Cr	Mo	Ni	Cu
Requirement	0.07-0.12	0.40-0.70	0.40-0.70	0.025	0.025	1.2-1.5	0.40-0.65	0.20	0.35
Actual Result	0.08	0.42	0.60	0.006	0.012	1.3	0.52	—	0.07

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥550	≥470	≥19	
Actual Result	620	505	23	