

AK ER80S-B6

Description: AK-ER80S-B6 is a gas-shielded solid welding wire for 5%Cr-0.5%Mo chromium-molybdenum heat resistant steel. The welding wire has welding process performance and excellent high-temperature mechanical properties.

Application: It is mainly used for the welding of boiler superheaters, heat exchangers, pipes and pressure vessels, etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	V
Requirement	0.1	0.5	0.4-0.7	0.025	0.025	0.6	4.5-6.0	0.45-0.65	—
Actual Result	0.08	0.44	0.62	0.008	0.01	—	5.24	0.53	—

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550	≥470	≥ 17	—
Actual Result	610	520	20	—

Recommended welding parameters:

Diameter/ mm		0.8	1.0	1.2
Current (A)	F/H	80-250	100-360	170-390
	V/OH	60-160	80-220	

NOTE:

Before use, the workpiece needs to be preheated to 177°C-232°C.