

# ROYAL – ER 80SB8 (ER 80SB8)

AWS/ SFA 5.28 ER 80SB8

## Applications

It is used for welding base material of similar composition. Usually in the form of pipe or tubing.

## Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000 mm.

## Characteristics on Usage

It gives about 8.0 to 10.5% Chromium and 1.0 % Molybdenum type weld deposit. The alloy is an air hardening material and therefore when welding with this filler wire rod, preheat and post weld heat treatment are required

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10Max	0.40 – 0.70	0.50 Max	0.025 Max	0.025 Max	8.0 – 10.50	0.50 Max	0.85- 1.20

## Mechanical Properties Of Weld Metal

(After PWHT at  $745 \pm 150^{\circ}\text{C}$  for 1 Hr soaking)

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
550	470	17