

Specifications:

AWS A5.28
ASME SFA 5.28
AWS ER80S-B8
UNS S50480

Properties:

Tensile Strength: 80,000 psi min.
Yield Strength: 68,000 psi min
Elongation: 17% min.

Description:

WT 80S-B8 is typically used to weld materials that have similar composition. It is air hardening and is creep resistant. It is used in the petrochemical and refinery industries for piping, heat exchangers, and pressure vessels at service temperatures no more than 1100°F. Preheat and pwht are required for this filler metal, preheat and interpass temperatures should be between 400-500°F, no less than 400°F, while pwht is typically 1375°F for one hour.

Available in multiple sizes and diameters.

Chemical Composition (Wt%):

| Si | Mn | S | P | C | Cu | Cr | Mo | Ni |
|-----|-----------|-------|-------|------|------|----------|---------|-----|
| 0.5 | 0.40-0.70 | 0.025 | 0.025 | 0.10 | 0.35 | 8.0-10.5 | 0.8-1.2 | 0.5 |

Note: Single values are maximum unless otherwise noted

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.