

Tigrod ER80S-B8

ER80S-B8 is a non-copper-coated solid wire for TIG welding requiring creep strength. This 9% Chromium - 1% Molybdenum TIG rod is used to weld 9% Chromium - 1% Molybdenum steels (ASTM Section IX, P No 5B, Group 1) such as ASTM A335 Grade P9 or ASTM A213 Grade T9. Tigrod products are embossed on opposite ends with the alloy identification.

Specifications

Classifications

ASME SFA 5.28
AWS A5.28 : ER80S-B8

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Stress Relieved 1 hour(s) 746 °C (1375 °F)	538 MPa (78 ksi)	670 MPa (97 ksi)	24 %

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	X-bar
0.5-0.10	0.40-0.70	0.50	max 0.025	max 0.025	max 0.50	8.0-10.5	0.8-1.2	max 0.20	max 12 ppm

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	X-bar
0.07	0.50	0.40	0.003	0.005	9.00	1.00	< 15 ppm