

Dual Shield 8000-B2

Dual Shield 8000-B2 is an all-position flux cored electrode which contains 1.25% Cr - 0.5% Mo. The analysis is very similar to Dual Shield 88 CM, except 8000-B2 is for out-of-position welding. The weld metal analysis is similar to an E8018-B2 low Hydrogen electrode. Dual Shield 8000-B2 wire is used for the welding of such steel as 0.5% Cr - 0.5% Mo, 1% Cr-0.5% Mo, and 1.25% Cr - 0.5% Mo. This wire is designed for single or multiple pass welding. Shielding gases of 100% CO₂ and 75% Ar - Remainder CO₂ may be used.

Specifications

Classifications

AWS A5.36 : E81T1-M21PZ-B2
 ASME SFA 5.36
 ASME SFA 5.29
 AWS A5.36 : E81T1-C1PZ-B2
 AWS A5.29 : E81T1-B2C/E81T1-B2M

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
100% CO₂			
Stress Relieved 1 hour(s) 690 °C (1275 °F)	593 MPa (86 ksi)	680 MPa (99 ksi)	22 %
75% Ar - 25% CO₂			
Stress Relieved 8 hour(s) 690 °C (1275 °F)	558 MPa (81 ksi)	648 MPa (94 ksi)	24 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo
75% Ar - 25% CO₂						
0.06	0.70	0.60	0.008	0.009	1.30	0.50

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Efficiency (%)	Deposition Rate
75% Ar - 25% CO₂					
1.6 mm (1/16 in.)	410 A	33 V	889 cm/min (350 in./min)	88 %	6.35 kg/h (14 lbs/h)
1.2 mm (.045 in.)	150 A	28 V	508 cm/min (200 in./min)	86 %	1.91 kg/h (4.2 lbs/h)
1.4 mm (.052 in.)	245 A	28 V	635 cm/min (250 in./min)	86 %	3.31 kg/h (7.3 lbs/h)
1.6 mm (1/16 in.)	500 A	39 V	1270 cm/min (500 in./min)	87 %	9.11 kg/h (20.1 lbs/h)
1.2 mm (.045 in.)	290 A	33 V	1270 cm/min (500 in./min)	87 %	4.85 kg/h (10.7 lbs/h)
1.4 mm (.052 in.)	155 A	25 V	381 cm/min (150 in./min)	87 %	2 kg/h (4.4 lbs/h)
1.2 mm (.045 in.)	250 A	30 V	1016 cm/min (400 in./min)	87 %	3.86 kg/h (8.5 lbs/h)
1.2 mm (.045 in.)	330 A	34 V	1524 cm/min (600 in./min)	87 %	5.76 kg/h (12.7 lbs/h)
1.6 mm (1/16 in.)	300 A	30 V	35 cm/min (250 in./min)	87 %	4.63 kg/h (10.2 lbs/h)
1.4 mm (.052 in.)	430 A	37 V	1524 cm/min (600 in./min)	87 %	7.98 kg/h (17.6 lbs/h)
1.4 mm (.052 in.)	310 A	33 V	889 cm/min (350 in./min)	85 %	4.63 kg/h (10.2 lbs/h)

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1.6 mm (1/16 in.)	450 A	33 V	1016 cm/min (400 in./min)	87 %	7.3 kg/h (16 lbs/h)
1.6 mm (1/16 in.)	365 A	33 V	762 cm/min (300 in./min)	86 %	5.58 kg/h (12.3 lbs/h)
1.2 mm (.045 in.)	210 A	29 V	762 cm/min (300 in./min)	86 %	86 kg/h (6.3 lbs/h)
1.6 mm (1/16 in.)	190 A	27 V	38 cm/min (150 in./min)	87 %	2.77 kg/h (6.1 lbs/h)
1.4 mm (.052 in.)	360 A	36 V	1143 cm/min (450 in./min)	85 %	6.03 kg/h (13.3 lbs/h)