

TALARC B8 TIG

CLASSIFICATION

AWS SPECIFICATION	EN SPECIFICATION
AWS A 5.28: ER80S-B8	EN ISO 21952-A: WCrMo9

ALLOY TYPE

9Cr-0.5Mo content TIG rod to be used for the welding of creep resistant steel.

APPLICATIONS

Low alloy copper-coated TIG rod with 9%Cr and 1%Mo content to be used for the welding of creep resistant steel. It will find applications in chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600°C. Its corrosion resistance is superior to that of 5Cr-0.5Mo steels.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C%	Mn%	Si%	S%	P%	Cu%	Ni%	Cr%	Mo%
0.07	0.50	0.40	0.008	0.004	0.10	-	9.0	1.0

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on% 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
Argon	afterPWHT	660	750	19	150	-	-	-	-

WELDING GUIDELINES

Preheat and inter-pass temperature 200÷ 300°C. PWHT at 745°C for an hour.

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding positions: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter(mm)	2.4
Length(mm)	1000
Carton	5Kg
Current	DC-Straight (-) polarity

Diam.	5kg Tube
2.4mm	INTB824

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