



MODI TIG 80S-B2

Copper Coated Low Alloy Steel TIG Wire

CLASSIFICATION : AWS/A 5.28 : ER 80S-B2

CHARACTERISTICS & APPLICATIONS : Copper coated steel TIG welding wire alloyed with nominally 1.25% Chromium (Cr) and 0.50% Molybdenum (Mo). It is recommended for the TIG welding of 1/2Cr-1/2Mo, 1Cr-1/2Mo and 1 1/4Cr-1/2Mo steel pipes, plates and castings used at elevated service temp (upto 550°C) in the power and petrochemical industries etc. It is also suitable for the dissimilar TIG welding of Cr-Mo steel to carbon steel and for welding of case hardenable steels or steels which can be subsequently heat treated.

CHEMICAL ANALYSIS OF WIRE (%)

	C	Mn	Si	Cr	Mo
	0.07-0.12	0.40-0.70	0.40-0.70	1.20-1.50	0.40-0.65

Ni	S	P
0.20 max	0.025 max	0.025 max

MECHANICAL PROPERTIES OF ALL WELD DEPOSIT USING WELDING GRADE ARGON

Yield Strength	Ultimate Tensile Strength	Elongation
(N/mm ²)	(N/mm ²)	(%)
470 min	550 min	19

PACKING SPECIFICATION :

Wire Size(mm)	1.6x1000	2.0x1000	2.4x1000	3.15x1000
Pack Weight/Tube (Kg)	5.25	5.25	5.25	5.25
Weight/Box	21.0	21.0	21.0	21.0



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