



KISWEL – KC-80SB2

Classifications:

AWS A5.28-05: ER80S-B2
EN 21952-B: G 55 1CM

JIS Z 3317: YG1CM-G

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	S	Mo
0.07 – 0.12	0.40 – 0.70	0.40 – 0.70	1.20 – 1.50	<0.025	0.40 – 0.65

Description:

- For butt and fillet welding in power plants, heat exchangers and oil refinery applications for 1.25%Cr-0.50%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 470	min. 550	min. 17	80 (0°C)

Packaging:

MIG/MAG Wire (Ø in mm): 0.90 MM / 1.00 MM / 1.20 MM in 12.50 Kg Spools

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
0.90 mm	Ar + 2% O ₂	70	250	14	25
1.00 mm		100	350	16	34
1.20 mm		120	450	16	38



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