



# KISWEL

## KISWEL – T-80SB2

### Classifications:

EN ISO 21952-B: 2007: W 55 1CM  
AWS A5.28-05: ER80S-B2

KS D 7140: YGT1CM  
JIS Z 3316: YGT1CM

### Typical Chemistry Composition of Weld Deposit:

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

### Description:

- For butt and fillet welding of power plant, heat exchanger and oil refinery applications for 1.25%Cr-0.5%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Proper tungsten electrode extension from the tip of torch is 4~6mm in general.

### Typical Mechanical Properties:

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

### Packaging:

**GTAW Wire** (Ø in mm): 1.60 MM / 2.00 MM / 2.40 MM / 3.20 MM in 5.00 Kg Packing

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.60 mm	Ar	90	170	11	16
2.00 mm		90	180	12	18
2.40 mm		100	200	13	20
3.20 mm		120	250	13	22



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