



## ENAR WELD BRAZE PVT. LTD

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### 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 refineries such as 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.
- Preheat at 100°C to 200°C and post weld heat treatment at 620°C to 720°C is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

#### Typical Mechanical Properties:

Yield Strength  
(Mpa)  
min. 470

Tensile Strength  
(Mpa)  
min. 550

Elongation  
(%)  
min. 19