

# GETIG 80SB6

**IDENTIFICATION : Embossing Code No: ER 80S B6**

**SPECIFICATIONS:** AWS A 5.28: ER 80S-B6

## CHARACTERISTICS

Copper coated filler wire for welding 5% Cr / 0.5 % Mo, air hardening steel used for elevated temperature, creep service and corrosion resistance against steam, hot hydrogen gas and high sulphur crude oils. The welds are of radiographic quality.

## COMPOSITION OF THE WIRE (%)

C	Mn	Si	Cr	Cu
0.10 max	0.40- 0.70	0.50 max	4.50- 6.0	0.30 max
Ni	Mo	S	P	
0.60 max	0.45- 0.65	0.025 max	0.025 max	

## ALL WELDMECHANICAL PROPERTIES PWHT (740°C/2 hrs)

UTS (MPa)	YS (MPa)	ELN % (L=4D)	CVN Impact properties	
550-650	460-560	20-25	Temp	Joules
			27±2°C	30-80

## APPLICATIONS:

Petrochemical & Refineries,  
ASTM A 335 Grs P5, P5b, A217C5  
ASTM A199/A213 Grs T5 and T5b

**WELDING CURRENT:** DC (-)

**SHIELDING GAS:** Argon 7-10 lt/min

## RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	PACKING/PKT (KG)	PACKING/BOX (KG)
1.6	1000	5Kg	5 x 4 = 20 Kg
2.0	1000	5Kg	5 x 4 = 20 Kg
2.4 / 2.5	1000	5Kg	5 x 4 = 20 Kg
3.15 / 3.2	1000	5Kg	5 x 4 = 20 Kg

**Manufactured by: GEE LIMITED**

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West)  
Thane, Maharastra, India.  
Website: www.geelimited.com

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