



ISO 9001:2015 REGISTERED
Certificate No: 50040 & 50415

ER80S-B6 DATA SHEET

Pinnacle Alloys ER80S-B6

AWS CLASS ER80S-B6

CODE AND SPECIFICATION DATA:

AWS A5.28 ASME SFA 5.28

DESCRIPTION:

Pinnacle Alloys ER80S-B6 is a low alloy copper-coated solid wire with 5% Cr and 0.5% Mo content to be used for the welding of creep resistant steel. Pinnacle Alloys ER80S-B6 is suitable for applications in the chemical or petro-chemical industry and in the ammonia synthesis process. It can also be used for heat exchangers, boilers, piping, and pressure vessels for temperature service up to 1110°F (600°C). The weld metal has also been used for subsequent nitriding in the petro-chemical industries; for example, in the repair of some steels used for molds for injection-molding plastics.

BASE MATERIALS TO BE WELDED:

- A182 Gr F5
- A199 Gr T5
- A213 Gr T5
- A217 Gr C5
- A234 Gr WP5
- A335 Gr P5
- A336 Gr F5
- A387 Gr 5

DIAMETERS: .035", .045", 1/16", 3/32", 1/8", 5/32"

WELDING POSITIONS: All positions

WELDING GUIDELINES: Preheat and interpass temperature 390°F-570°F (200°C-300°C). PWHT at 1370°F (745°C) for one hour.

TYPICAL DEPOSIT COMPOSITION (Wt %):

Carbon (C)	0.07
Chromium (Cr)	5.80
Copper (Cu)	0.12
Manganese (Mn)	0.50
Molybdenum (Mo)	0.55
Phosphorous (P)	0.008
Silicon (Si)	0.40
Sulfur (S)	0.008

TYPICAL MECHANICAL PROPERTIES (after PWHT):

Ultimate Tensile Strength (psi) 89,930 psi (620 MPa)
Yield Strength (psi) 72,520 psi (500 MPa)
Percent Elongation 25%
CVN (ft•lb) @ 68°F (20°C) 60 ft•lbs (70 Joules)

www.pinnaclealloys.com

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TYPICAL WELDING PARAMETERS:

	Diameter	Amperage	Volts	Shielding Gas
GTAW	.035"	50-70	10-12	100% Ar
	.045"	70-100	10-12	
	1/16"	100-125	12-15	
	3/32"	125-175	15-20	
	1/8"	175-250	15-20	
	5/32"	175-250	15-20	
GMAW – Spray Transfer	.035"	165-200	28-32	80-85% Ar/ Bal CO ₂ 95-98% Ar/ Bal O ₂
	.045"	180-220	30-34	
	1/16"	230-260	30-34	
GMAW – Short Circuiting Transfer	.035"	100-140	22-25	100% CO ₂ * 75% Ar/ 25% CO ₂ **
	.045"	120-150	23-26	

*With 100% CO₂ gas shielding, weld metal undergoes short circuit or globular transfer.

**Only facilitates short circuit or globular transfer.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys MSDS sheet may be obtained at www.pinnaclealloys.com.

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