

Mild Steel & Low Alloy Steel Welding Filler Wire

Product: Swastik Weld 80S-B2 WIRE

AWS A5.28 ER 80S-B2

Typical Application:

1.25Cr-0.5%Mo Heat Resistance steels

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Mo	
0.09	0.54	0.51	1.26	0.45	

Typical Mechanical Properties of all- weld- metal

Y.P N/mm2 (kgf/mm2)	T.S N/mm2 (kgf/mm2)	El (%)	PWHT
500 (51)	590(60)	26	620°C x 1hr

Standard Sizes:

Diameters (mm) = 1.2, 1.6, 2.0, 2.40, 3.15

Packing:

Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

Note: We can supply wires & fluxes to stringent specifications for welding of various materials:
Steels (Carbon, Carbon Manganese, Carbon – Moly, Low Alloy, High Tensile, Stainless),
Nickel, Aluminum, Copper & their alloys by TIG / MIG / MAG /SA Processe

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