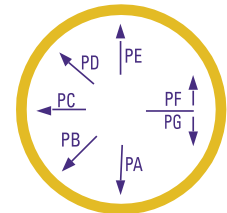


## Applications

- TTC 80S-B2 is used to weld 1.25%Cr - 0.5%Mo steels used for high temperature service,
- High pressure pipe & Pressure vessels.

## Welding Position



## Features

- Careful control of preheat, interpass temperature, postheat is essential to avoid cracking.
- X-factor value of wire is 10ppm or less.

## Typical Chemical Composition of weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.085	0.57	0.62	0.011	0.004	0.05	1.38	0.51

## Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Ys Mpa	TS MPa	E L (%)	Temp °C	CVN- Impact Value (J)
As welded with 100% Ar	480	595	27	-30	130

## Dimensions and Packing Details

2.0mm x1000mm 5KgTube  
2.4mm x1000mm 5KgTube  
3.2mm x1000mm 5Kg Tube

## Current

DC+