S-800CM × B-2

TYPE : Neutral

AWS A5.23/ASME SFA5.23 F8P2-EB2-B2
EN 760 S A FB 1
EN ISO 14174 S A FB 1 / EN ISO 14171 S2CrMo1

Applications

S-800CM X B-2 is Single-layer welding of various kinds of structure such as 1.25%Cr-0.5% heat resistant steels used for boilers.

Characteristics on Usage

Especially insensitive to oil, rust, scale, and dirt on the surface to be welded. It produces the weld metal which has excellent impact value at low temperature service.

Notes on Usage

① Dry the flux at 300~350° C (572~662° F) for 60 minutes before use.
② When the flux height is excessive, poor bead appearance may occur.
③ Use welding current and speed as low as possible at the first layer of groove to avoid cracking.
④ Preheat the thick plate according to rules if it has heavy restricted stress.

Approval	I Current	I Basicity Index
	AC or DC+	3.2

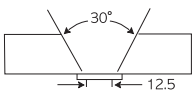
Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	P	S	Cr	Mo	BM	Th.(mm)
B-2	0.08	0.25	0.84	0.017	0.004	1.21	0.45	SM570	25

Typical Mechanical Properties of All-Weld Metal

Wire	YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)	BM	Th.(mm)
B-2	610 (88,500)	665 (96,400)	25.6	-29 (-20)	40 (34)	SM570	25

Typical Welding Conditions

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
B-2	4.0	25		1~13	570	30	40	AWS A5.23