

**Specifications:**

AWS A5.28  
ASME SFA 5.28  
AWS ER80S-B2  
UNS K20900

**Properties:**

**Tensile Strength:** 80,000 psi min.  
**Yield Strength:** 68,000 psi min  
**Elongation:** 19% min.

**Description:**

WT 80S-B2 is creep resistant mild steel and are often used in chemical industries. Preheat and interpass temperatures are usually kept between 275-325°F. Careful control of temperatures for interpass, preheat and post heat should be taken to avoid cracking. Recommended shielding gas is CO<sub>2</sub> or an Ar/CO<sub>2</sub> mixture.

Available in multiple sizes and diameters.

**Chemical Composition (Wt%):**

Si	Mn	S	P	C	Cu	Cr	Mo	Ni	Other
0.40-0.70	0.40-0.70	0.025	0.25	0.07-0.12	0.35	1.20-1.50	0.40-0.65	0.2	0.5

Note: Single values are maximum unless otherwise noted

**Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**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, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.