Oxford® ALLOYS, Inc.
Supplier of Welding Alloys

Mild and Low Alloy Steel TIG, MIG and SUB-ARC Wire

Oxford Alloy® 80S-B6 (502)

SPECIFICATIONS
AWS 5.28
ASME SFA 5.28

CLASSIFICATIONS
AWS ER80S-B6
UNS S50280

DESCRIPTION / APPLICATION
Oxford Alloy ER80S-B6 is designed for welding of materials of similar composition, for high temperature service conditions. This alloy is an air-hardening material and as such calls for preheat and interpass temperatures of 350℉ minimum during welding. Formerly known as Oxford Alloy ER502 AWS / ASME SFA 5.9.

*Note: Mechanical properties listed above reflect utilization of a post-weld heat treatment between 1550℉ and 1600℉ for two hours.

AWS Chemical Composition

C	Mn	Si	Cr	Mo	S	P
0.10 max	0.40-0.70	0.50 max	4.50-6.00	0.45-0.65	0.025 max	0.025 max
Ni	**Cu**	**OET**				
0.6 max	0.35 max	0.50 max				

TYPICAL MECHANICAL PROPERTIES

Tensile strength:	91,350 psi	630 MPa
Yield strength:	69,600 psi	480 MPa
Elongation:	25%	

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.