

Oxford Alloy® 80S-B6

AWS ER80S-B6 • Chrome Moly



Key Features

- ❖ Designed for welding of materials of similar composition, for high temperature service conditions.
- ❖ Air-hardening material therefore calls for preheat and interpass temperatures of 350°F minimum during welding.
- ❖ Typical applications include power generation, pressure vessels, petrochemical, and process piping.

Conformances

AWS/ASME SFA 5.28
ER80S-B6
UNS S50280

Chemical Composition - As required per AWS 5.28

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				

Mechanical Properties - As required by AWS 5.28

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
AWS Requirements	550 (80) min	470 (68) min	17 min
Typical Results ^(a) - As welded	630 (91)	480 (70)	25

Typical Welding Parameters

Diameter		Process	Volt	Amps	Shielding Gas
in	(mm)				
.035	0.9	GMAW	28-32	165-200	Spray Transfer 98% Argon + 2% Oxygen or 75% Argon + 25% CO ₂
.045	1.2	GMAW	30-34	180-220	
1/16	1.6	GMAW	30-34	230-260	
.035	0.9	GMAW	22-25	100-140	Short Circuiting Transfer 100% CO ₂ or 75% Argon + 25% CO ₂
.045	1.2	GMAW	23-26	120-150	
1/16	1.6	GMAW	23-26	160-200	
1/16	1.6	GTAW	12-15	100-125	100% Argon
3/32	2.4	GTAW	15-20	125-175	100% Argon
1/8	3.2	GTAW	15-20	175-250	100% Argon

Diameters & Packaging

Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
.035	GMAW	33 lb spool 1980 lb pallet	0.9	GMAW	15 kg spool 900 kg pallet
.045	GMAW	33 lb spool 1980 lb pallet	1.2	GMAW	15 kg spool 900 kg pallet
1/16	GMAW	33 lb spool 1980 lb pallet	1.6	GMAW	15 kg spool 900 kg pallet
1/16	GTAW	10 lb tube 40 lb carton	1.6	GTAW	5 kg tube 20 kg carton
3/32	GTAW	10 lb tube 40 lb carton	2.4	GTAW	5 kg tube 20 kg carton
1/8	GTAW	10 lb tube 40 lb carton	3.2	GTAW	5 kg tube 20 kg carton

^(a) Typical Results are based on Preheat, Interpass, and PWHT temperatures per AWS 5.28. Actual test results may vary. Refer test result disclaimer on page 160.