

Dual Shield 8000-B2(L)

AWS A5.29 E81T1-B2C / JIS Z3318 YF1CM-C

Description

- Dual Shield 8000-B2 is an all-position flux cored electrode which contains 1.25% Cr-0.5% Mo.

The analysis is very similar to Dual Shield 88 CM, except 8000-B2 is for out-of-position welding.

The weld metal analysis is similar to an E8018-B2 low Hydrogen electrode. Dual Shield 8000-B2 wire is used for the welding of such steel as 0.5% Cr-0.5% Mo, 1% Cr-0.5%Mo, and 1.25% Cr-0.5% Mo.

The wire is designed for single or multiple pass welding.

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	PWHT
640 {65}	720 {73}	20	As-Welded
600 {61}	680 {69}	21	620 °C × 1hr

Typical Undiluted Weld Metal Analysis %

구분	C	Mn	Si	Cr	Mo
Dual Shield 8000-B2	0.058	0.65	0.58	1.30	0.55
Dual Shield 8000-B2L	0.03				

Preheat & Interpass, PWHT Temperature

Base Metal	Preheat & Interpass Temp.	PWHT Temp
0~1%Cr-0.5%Mo Steel	212~392°F (100~200°C)	1.202~1.292 °F(650~700 °C)
1~25%Cr-0.5%Mo Steel	302~572°F (150~300°C)	1.202~1.292 °F(650~700 °C)
2~25%Cr-1.0%Mo Steel	392~662°F (220~350°C)	1.224~1.350 °F(680~730 °C)