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COR™STAIN E80T5-B6

DESCRIPTION

COR™STAIN E80T5-B6 is an AISI 5%Cr-0.5%Mo steel flux cored wire designed for heat resistance. It was previously available as 502 FC.

APPLICATIONS

E80T5-B6 is used to weld chrome-moly pipe and tube, and other similar base materials. It is also used as an underlay for harder heat resisting filler metals.

PROCEDURE

E80T5-B6 is an air hardening alloy: Maintain a preheat/interpass temperature of at least 350°F. Post heat according to base material. Recommended post heat is at 1575°F for one hour per inch thickness.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas	Stickout
.035"	24-28	100-150	CO ₂ or Ar-CO ₂ mixture	0.5"
.045"	24-28	150-200	CO ₂ or Ar-CO ₂ mixture	0.5"
1/16"	26-30	200-300	CO ₂ or Ar-CO ₂ mixture	0.75"

MECHANICAL PROPERTIES

Hardness: 32-37 Rc

CLASSIFICATION

AWS A5.29-98, Class E80T5-B6