

Dual Shield 8000-B2

Dual Shield 8000-B2 is an all-position 1.25Cr-0.5Mo flux cored wire for welding creep resistant steels of type 0.5Cr-0.5Mo, 1Cr-0.5Mo and 1.25Cr-0.5Mo.

Specifications

Classifications	SFA/AWS A5.29 : E81T1-B2C
Welding Current	DC+
Alloy Type	Cr-Mo alloyed
CTOD-Tested	false

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
Stress Relieved	520 MPa	610 MPa	24 %

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
C1 shielding gas				
0.058	0.65	0.58	1.30	0.55

Deposition Data

Diameter	Current	Voltage
1.2 mm	140-330 A	22-34 V
1.6 mm	160-430 A	24-36 V