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

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Shielding Gas</th>
<th>Stickout</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035&quot;</td>
<td>24-28</td>
<td>100-150</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.5&quot;</td>
</tr>
<tr>
<td>.045&quot;</td>
<td>24-28</td>
<td>150-200</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.5&quot;</td>
</tr>
<tr>
<td>1/16&quot;</td>
<td>26-30</td>
<td>200-300</td>
<td>CO₂ or Ar-CO₂ mixture</td>
<td>0.75&quot;</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES
Hardness:  32-37 Rc

CLASSIFICATION
AWS A5.29-98, Class E80T5-B6