

## Select 810-B8

### Description

Select 810-B8 is an all position, flux cored electrode formulated for single and multiple pass welding of 9 chromium and 1 molybdenum steels.

### Classification

- E81T1-B8M per AWS A5.29, ASME SFA 5.29

### Characteristics

- Uniform weld beads with good tie-in.
- Smooth and stable arc transfer.
- Greater tolerance for mill scale and rust.
- Increased deposition rates compared to covered and solid electrodes.
- Eliminates lack of fusion defects.

### Application

Select 810-B8 is used to weld 9Cr-1Mo steels such as A335-P9 piping and A213-T9 tubing. Typical applications involve high temperature service in the petrochemical and petroleum industry.

### Typical Mechanical Properties:

	<b>SR 2 Hr. @ 1375° F</b>
<b>Ultimate Tensile Strength</b>	96,300
<b>Yield Strength (psi)</b>	78,000
<b>Percent Elongation</b>	20

### Typical Deposit Composition:

<u>WT %</u>	<u>C</u>	<u>Cr</u>	<u>Mo</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>
	.09	9.30	1.05	.50	.35	.010	.010

### Recommended Welding Parameter:

<u>Diameter</u>	<u>Position</u>	<u>Optimum</u>			<u>Range</u>	
		<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
1/16"	Flat	350	350	28	150-400	21-33
	Overhead	225	170	25	150-310	21-27
	Vertical up	225	170	24	150-280	21-26
.052"	Flat	300	440	27	100-330	18-31
	Overhead	200	245	25	150-310	20-27
	Vertical up	200	245	24	150-280	20-26
.045"	Flat	250	450	27	100-300	20-31
	Overhead	200	300	25	150-280	20-28
	Vertical up	200	300	24	100-230	20-27

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**Notice:** The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.