

CLASSIFICATION

AWS A5.28: ER80S-B6
TS EN ISO 21952-A : W CrMo5Si
EN ISO 21952-A: W CrMo5Si

GENERAL DESCRIPTION

It is a low alloyed TIG rod, used for the welding high temperature strength Cr-Mo (5 % Cr, 0.5 % Mo) steels (boiler and pressure vessels) in operating temperatures up to 600°C. It gives a weld metal that has creep and hydrogen resistance.

Industry: Thermal plants, chemical and petro-chemical industry

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Mo	Cu
0.08	0.45	0.60	<0.20	5.70	0.60	< 0.25

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 560 N/mm²
Tensile Strength : 660 N/mm²
Elongation (L=5d) : 22 %
Impact (ISO-V) : 180 J (+20°C)
50 J (-20°C)

SHIELDING GASES (ISO 14175 / EN 439)

TIG : I1 - Ar (100%)
Current Type and Polarity : DC (-)

MATERIALS TO BE WELDED

	<u>DIN</u>	<u>EN</u>	<u>Wr. Nr</u>
Creep Resistant Steels	12 CrMo 19 5	X12CrMo5	1.7362
Cast Steels	GS-12 CrMo 9 5	GX12CrMo5	1.7363

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Tube Weight
TIG ROD	-	-	-	X	X	X	-	5 kg

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.