

TIG Rod for High Strength and Low Alloyed Steels

Classification

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

	DIN	EN	Wr. Nr.
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