

CLASSIFICATION

AWS A5.28: ER80S-B2
TS EN ISO 21952-A : W CrMo1Si*
EN ISO 21952-A: W CrMo1Si*

(*) Nearest classification

GENERAL DESCRIPTION

It is a low alloyed TIG rod, used for the welding high temperature strength Cr-Mo (1.25 % Cr, 0.5 % Mo) steels (boiler and pressure vessels) in operating temperatures up to 550°C. Also It is used in the welding cementation and nitride steels.

Industry: Chemical and petro-chemical industry

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Mo	Cu
0.08	0.55	0.60	<0.20	1.30	< 0.55	< 0.30

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 510 N/mm²
Tensile Strength : 620 N/mm²
Elongation (L=5d) : 24 %
Impact (ISO-V) : 120 J (+20°C)
100 J (-10°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	15 CrMo 5	-	1.7205
	25 CrMo 4	-	1.7218
	42 CrMo 4	-	1.7225
	13 CrMo 44	13 CrMo 4-5	1.7335
	22 CrMo 44	-	1.7350
	13 CrMoV 42	-	1.7709
	16 CrMoV 4	-	1.7728
Cast Steels	GS-25 CrMo 4	G25CrMo4	1.7218
	GS-22 CrMo 5 4	G22CrMo5-4	1.7354
	GS-17 CrMo 5 5	G17CrMo5-5	1.7357
Cementation Steels	-	16MnCr5	1.7131

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.

Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk