

TIGWELD CrMo

TIG Rods [GTAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 21952-A : W CrMo1Si DIN 8575 : SG CrMo1 AWS A-5.28 : ER 80S-B2 (ER 80S-G)	UDT, TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Wire with the addition of Cr and Mo for TIG welding.
- Used for welding creep-resistant steels working under pressure and at high temperatures.
- Used in the chemical and petrochemical industry.
- Weld working temperature up to 550°C.
- Bruscato's factor of $X < 10\text{ppm}$ ensures high resistance to temper brittleness.

Application

Steam boilers, pipelines, fittings. Repair of thermoenergetic devices

Base material

	EN
Boiler plates:	13CrMo45
1.25%Cr, 0.5%Mo ferritic creep resistant steels	
	13CrMo 4-4, 13CrMo 4-5, 16CrMo 4-4, GS-17CrMo 5-5
ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12	

Typical chemical composition %

C	Si	Mn	Cr	Mo
0,10	0,60	1,0	1,2	0,50

Typical mechanical properties

Yield strength Re [N/mm²]	>355
Tensile strength Rm [N/mm²]	>510
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-40°C) /
Heat treatment	Annealing: 720°C / 30 min, furnace cooling to 300°C, then in air
Additional description	X Factor: max 10 ppm
Shielding gases acc. to EN ISO 14175	I1 - Ar /
Remarks	Preheating temperature 200°C. Interpass temperature max 300°C.

Welding parameters and packing

Ø	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0/25,0
2,0	1000 /	5,0/25,0
2,4	1000 /	5,0/25,0
3,0	1000 /	5,0/25,0

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