

Classifications

EN ISO 21952-A	EN ISO 21952-B	AWS A5.28	Wst.-Nr.
G CrMo1Si	G 55 M21 1CM3	ER80S-G	1.7339

Characteristics and typical fields of application

Low-alloyed solid wire electrode useable both with CO₂ and with gas mixture.

Applications include the welding of creep resistant steels in boiler, tank, pipeline and reactor construction.

Base materials

1.7335 – 13CrMo4-5; 1.7262 – 15CrMo5; 1.7218 – 25CrMo4; 1.7225 – 42CrMo4;

1.7354 – G22CrMo5-4; 1.7357 – G17CrMo5-5;

ASTM A 182 Gr. F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A 335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12;

Typical analysis of solid wire (wt.-%)

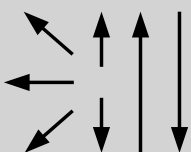
	C	Si	Mn	Cr	Mo
wt-%	0.09	0.60	1.05	1.10	0.50

Mechanical properties of all-weld metal

Heat-treatment	Shielding gas	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
		MPa	MPa	%	+20 °C
A	M21*	450	560	22	80

*Also weldable with CO₂. In this case the mechanical properties will change.

Operating data

	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M1 – M3 und C1	ø mm 0.8 1.0 1.2	Spool: B300 B300 B300
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Approvals

TÜV (00905), DB (42.132.19), CE