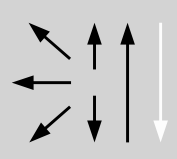


Classifications					
EN ISO 21952-A	EN ISO 21952-B	AWS A5.28			Wst.-Nr.
W CrMo1Si	W 55 1CM3	ER80S-G [ER80S-B2(mod.)]			1.7339
Characteristics and typical fields of application					
Welding rod / wire for the welding with argon. Suitable for manufacturing creep resistant steels in boiler, tank, pipeline and nuclear reactor construction.					
Base materials					
High temperature and creep resistant steels and cast steels 1.7335 13CrMo4-5, 1.7262 15CrMo5, 1.7728 16CrMoV4, 1.7218 25CrMo4, 1.7225 42CrMo4, 1.7258 24CrMo5, 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; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12;					
Typical analysis of the TIG rods (wt.-%)					
	C	Si	Mn	Cr	Mo
wt-%	0.10	0.60	1.00	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	l1	450	560	22	90
Operating data					
	Polarity: DC (–)	Shielding gas: (EN ISO 14175) I 1-3	Marks: ✦ W CrMo1Si / ER80S-G	ø mm	L mm
				2.0	1000
				2.5	1000
				3.2	1000
Approvals					
TÜV (00906), DB (42.132.44), CE					