

Classifications

EN ISO 636-A / 21952-A	EN ISO 636-B / 21952-B	AWS A5.28
W 46 3 W2Mo / MoSi	W 55A 3U W2M31 / W 52 1M3	ER80S-G(A1)

Characteristics and typical fields of application

Low-alloyed welding rod/wire for the welding with argon. Suited for low alloy and creep resistant steels in pipe and tank construction.

Base materials

Creep resistant steels and cast steels, fine grained structural steels up to 460 MPa (67 ksi)
 16Mo3, 17MnMoV6-4, 20MnMoNi4-5, 20MnMo3-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
 ASTM A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65

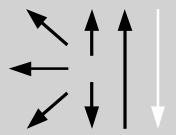
Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Mo
wt.-%	0.10	0.60	1.15	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	-30 °C
u	l1	480	570	23	110	47

Operating data

	Polarity:	Shielding gas:	Marks:	Ø mm	L mm
	DC (-)	(EN ISO 14175)	✦ W MoSi /	1.6	1000
		I1 - I3	ER80S-G (A1)	2.0	1000
				2.4	1000
				3.2	1000

Approvals

TÜV (01250), DB (42.132.43), CE