

Low alloy solid rod

Classification

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

* Nearest classification

General description

Solid rod for welding creep and hydrogen resistant Cr-Mo steels
 Service temperature up to 550°C

Shielding gases (acc. ISO 14175)

I1 Inert gas Ar (100%)

Approvals

TÜV

+

Chemical composition (w%) typical wire / rod

C	Mn	Si	Cr	Mo
0.1	1.0	0.5	1.2	0.5

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	SR 700°C/1h	540	640	22	250

Materials to be welded

Steel grades	Code	Type
Elevated temperature steel	EN 10028-2	13 CrMo4-5
	EN 10083-1	25 CrMo 4
	EN 10222-2	14 CrMo 4-5
Tool steel	DIN 17210	16 MnCr 5

Application advice

Preheating welding joint acc. EN 1011-1, 200-250°C
 Post weld heat treatment at 660-700°C

Packaging and available sizes

Unit type	Diameter (mm)		
	1.6	2.0	2.4
2 and 5 kg tube	X	X	X
Other sizes and packaging on request			

LNT 19: rev. EN 21

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