Low alloy solid rod

Classification

AWS A5.28 : ER80S-B6
ISO 21952-A : W CrMo5Si

General description

Solid rod for welding of creep and hydrogen resistant 5%Cr, 0.5%Mo steels
Service temperature up to 550°C

Shielding gases (acc. ISO 14175)

I1 Inert gas Ar (100%)

Chemical composition (w%),Typical, rod

C	Mn	Si	Cr	Mo
0.08	0.5	0.3	5.8	0.6

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 750°C/1h	560	650	20	80

Materials to be welded

Steel grades	Standard	Type
Creep and hydrogen resistant steels	SEW 028	12CrMo 19-5 and corresponding steels
	ASTM A182	F5
	ASTM A213	T5
	ASTM A335	P5
	ASTM A336	F5
	ASTM A369	FP5
	ASTM A387	Grade 5

Application advice

Recommended preheat and interpass temperature 200-300°C
Recommended post weld heat treatment at range 675-750°C (time depending on material thickness)

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

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

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