

SG CrMo1

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated welding wire for welding creep and hydrogen-resistant steels.

APPLICATIONS High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.

PROPERTIES Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas. Suitable to offer creep resistance for working temperatures up to 550° Celsius.

CLASSIFICATION

AWS	A 5.28: ER 80S-G
EN ISO	21952-A: G CrMo1Si
DIN: W.Nr.	1.7339
DIN	8575: SG CrMo1

SUITABLE FOR 13CrMo4 5 (1.7335), 15CrMo5, 16CrMoV4, 22Mo4, G22CrMo5 4 (1.7354) G17CrMo5 5 (1.7357) A193 Grade B7, A335 Grade P11, A335 Grade P12, 42CrMo4 (Rm < 780 Mpa), 13CrMo44, 24CrMo5, 13CrMo4-5, A 387, Gr. 11 - 12, GS 17CrMo55, GS 22CrMo54, G17CrMo5-5, G22CrMo5-4

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Cu	Mo
0.09	1.00	0.60	1.15	< 0.25	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		Shield gas En 439	Hardness HRC / HV
				20°C	-40°C		
SR	> 450	> 560	> 22	> 80		M21	

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8			KD-300 / Drum	15 / 250	1080 / 1000
1.0			KD-300 / Drum	15 / 250	1080 / 1000
1.2			KD-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE not required