

Classifications

EN ISO 21952-A	AWS A5.28	Material-No.
G CrMo1Si	ER80S-G	1.7339

Characteristics and field of use

Medium alloy solid wire electrode useable both with CO₂ and with gas mixture. Applications include the welding of creep resistant steels in boiler, tank, pipeline and reactor construction.

Base materials

1.7335 – 13CrMo4-5; ASTM A193 Gr. B7; A335 Gr. P11 und P12;
 1.7357 – G17CrMo5-5 – A217 Gr. WC6

Typical analysis in %

C	Si	Mn	Cr	Mo
0.09	0.6	1.05	1.1	0.5

Mechanical properties of the weld metal

Heattreatment	Shielding gas	0.2%-Yield strength	Tensile strength	Elongation (L ₀ =5d ₀)	Impact values CVN
		MPa	MPa	%	J
A	M21*	450	560	22	80

*) Also weldable with CO₂. In this case the mechanical properties will change.

Approvals

TÜV (No. 00905), DB (No. 42.132.19)

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
0.8	DC (+)	M1	M2	M3	C1
1.0	DC (+)	M1	M2	M3	C1
1.2	DC (+)	M1	M2	M3	C1

Other spool types on request.

