Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.12

Signed by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

Classification weld metal, chemical composition changed.

GENERAL

A copper coated, low alloyed, chromium-molybdenum (1% Cr, 0,5% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed high strength steels with a minimum tensile strength of 550 Mpa.

Shielding Gas: I1 (EN 439)

Alloy Type: Low alloyed steel (1 % Cr - 0.5 % Mo)

CLASSIFICATIONS Wire Electrode

EN 12070	W CrMo1Si
SFA/AWS A5.28	ER80S-G
DIN 8575	W.nr. 1.7339

APPROVALS

UDT	DIN 8575
VdTÜV	04952

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	**Min**	**Max**
C	0.1	0.08	0.12
Si	0.7	0.50	0.70
Mn	1.0	0.80	1.20
P	0.010		0.020
S	0.015		0.020
Cr	1.1	1.00	1.30
Mo	0.5	0.40	0.60

MECHANICAL PROPERTIES OF WELD METAL

	All Weld Metal			
	Ar (I1) AWS As welded		Ar (I1) EN Stress relieved 700°C 0,5h	
Properties	**Min**	**Typ**	**Min**	**Typ**
Rp0.2 (MPa)	470	560	355	560
Rm (MPa)	550	720	510	650
A4-A5 (%)	19	24	20	26
Z (%)		70		
Charpy V at 20°C (J)		120	47	180
Charpy V at -20°C (J)		50		
Charpy V at -30°C (J)		40		
Charpy V at -40°C (J)		20		
Charpy V at -60°C (J)		20		

OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 1.0, 1.6, 2.0, 2.4, 3.2 and 4.0 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.