

## SG CrMo1 TIG

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. 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
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APPROVALS	CE approved
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### WELDING POSITIONS:



WELD METAL ANALYSIS %					
C	Mn	Si	Cr	Cu	Mo
0.09	1.00	0.60	1.15		0.50

MECHANICAL PROPERTIES							
Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Shield gas En 439	Hardness HRc / HV
				20°C	-40°C		
	>450	>560	>22	> 80	>47	I1	

Preheat 200°C / Interpass temp max. 300°C

### WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing (kg)	
	Voltage (V)	Current (A)	single	master
1.2 x 1000		30-70	5	25
1.6 x 1000		50-80	5	25
2.0 x 1000		70-110	5	25
2.4 x 1000		110-180	5	25
3.2 x 1000		150-250	5	25

REDRYING TEMPERATURE	Not required
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GAS ACC. EN ISO 14175:	I1
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