

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 EN ISO DIN: W.Nr. DIN	A 5.28: ER 80S-G 21952-A: G CrMo1Si 1.7339 8575: SG CrMo1
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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	< 0.25	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V 20°C -40°C	Shield gas En 439	Hardness HRC / HV
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
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