

SG CrMo5

CATEGORY GMAW-GTAW Solid wires

TYPE Medium alloyed, high-strength 5% Chromium alloy.

APPLICATIONS Mainly used in pipeline, apparatus and boiler application. This alloy is specially intended for high integrity structural service at elevated temperature.

PROPERTIES Designed for welding heat resistant steels to sustain working temperatures upto 650°C

CLASSIFICATION

AWS	A 5.28: ER 80S B6
EN ISO	21952-A: G CrMo5Si
DIN: W.Nr.	1.7373
DIN	8575: SG CrMo5

SUITABLE FOR A213 Grade T5, A217 Grade C5, A335 Grade P5, GX12CrMo5 (1.7362), X12CrMo5 (1.7363), Upto 1180 MPa

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo
0.08	0.50	0.45	5.7	0.6

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				20°C	40°C
AW (min.)	430	550	17	47	
SR	> 460	> 590	> 18	> 110	

Min. : minimum values, SR: stress relieved PWHT 720°C /2 Hr (Typical)

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing	
	Voltage (V)	Current (A)	Spool type	kg / spool	kg / 1000
0.8	15-24	60-200	S/D 300	15	1080
1.0	16-32	80-300	S/D 300	15	1080
1.2	18-35	120-380	S/D 300	15	1080

REDRYING TEMPERATURE not required

TIG WELDING 1000 mm.cut lenghts are available from 1,6 till 3,2 mm. in 5 kg tubes.