


CATEGORY	GMAW Solid wires																						
TYPE	Copper coated welding wire for welding creep resistant ferritic steels.																						
APPLICATIONS	Filler metal for high temperature creep resistant 1.25%Cr0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.																						
PROPERTIES	The filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor($X < 10$ ppm)for temper embrittlement resistant applications.																						
CLASSIFICATION	AWS	A 5.28: ER 80S-B2																					
	EN ISO	21952-B: G 1CM																					
	F-nr	6																					
	FM	3																					
SUITABLE FOR	For matching 1.25%Cr0.5%Mo creep resisting ferritic steels. 13CrMo4-5, 16CrMo4-4, GS-17CrMo5-5 ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12																						
APPROVALS	CE																						
WELDING POSITIONS:																							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>0.6</td> <td>0.6</td> <td>1.3</td> <td>0.5</td> </tr> </tbody> </table>			C	Si	Mn	Cr	Mo	0.09	0.6	0.6	1.3	0.5										
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REDRYING TEMPERATURE	Not required																						
GAS ACCORDING EN 14175	M21																						