


CATEGORY	GTAW Solid wires																																			
TYPE	Tig filler metal for Medium alloyed, high-strength grade 5 steels.																																			
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 up to 650°C																																			
CLASSIFICATION	AWS	A 5.28: ER 80S-B6																																		
	EN ISO	21952-A: W CrMo5Si																																		
	F-nr	6																																		
	FM	3																																		
	W.Nr.	1.7373																																		
SUITABLE FOR	For matching 5%Cr-0.5%Mo creep resisting ferritic steels GX12CrMo5 (1.7362), X12CrMo5 (1.7363), Upto 1180 MPa																																			
	ASTM: A182/A336 grade F5, A199/A213 grade T5, A217 grade C5, A234 grade WP5, A335 grade P5, A387 grade 5																																			
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> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.6</td> <td>6</td> <td>0.6</td> <td></td> <td></td> </tr> </tbody> </table>						C	Si	Mn	Cr	Mo			0.08	0.4	0.6	6	0.6																		
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