

Classifications

TIG rod

EN ISO 21952-A	AWS A5.28	Material-No.
W CrMo1Si	ER80S-G [ER80S-B2(mod.)]	1.7339

Characteristics and field of use

Welding rod for the welding with argon. Suitable for manufacturing creep resistant steels in boiler, tank, pipeline and nuclear reactor construction.

Base materials

1.7335 – 13CrMo4-5, ASTM A193 Gr. B7;
 1.7357 – G17CrMo5-5 – A217 Gr. WC6;
 A335 Gr. P11 u. P12

Typical analysis of rod and wire in %

C	Si	Mn	Cr	Mo
0.1	0.6	1.0	1.1	0.5

Mechanical properties of the weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A	Impact strength K_V
	MPa	MPa	%	J [RT]
annealed	450	560	22	90

Approvals

TÜV (No. 00906), DB (No. 42.132.44)

Form of delivery

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
2.0 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1