

# UTP A 641

Unalloyed and low alloyed steels

**Classifications** solid wire

EN ISO 21952-A	AWS A5.28	Material-No.
G CrMo1Si	ER80S-G	1.7339

## Characteristics and field of use

Medium alloy solid wire electrode useable both with CO<sub>2</sub> and with gas mixture. Applications include the welding of creep resistant steels in boiler, tank, pipeline and reactor construction.

## Base materials

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

## Typical analysis in %

C	Si	Mn	Cr	Mo
0.09	0.6	1.05	1.1	0.5

## Mechanical properties of the weld metal

Heat-treatment	Shielding gas	0.2%-Yield strength	Tensile strength	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact values CVN
		MPa	MPa	%	J
A	M 21*	450	560	22	80

\*) Also weldable with CO<sub>2</sub>  
In this case the mechanical properties will change.

## Approvals

TÜV (No. 00905), DB (No. 42.132.19)

## Form of delivery and recommended welding parameters

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
0.8	DC (+)	M 1	M 2	M 3	C 1
1.0	DC (+)	M 1	M 2	M 3	C 1
1.2	DC (+)	M 1	M 2	M 3	C 1

Other spool types on request.