



HILCO FER SGCrMo1

TIG rods – low alloyed steel – creep resisting

AWS A5.28: ER 80S-B2

EN ISO 21952-B : 1 CM

Wire type:

TIG Solid wire

Current:**Welding positions:****Shielding gas:**

I1

Fer SGCrMo1 ER 80S-B2 is our solid wire for TIG welding low alloyed fine grain and creep resisting steels like 13CrMo4 5 up to a maximum operating temperature of 550°C. Typical applications include the construction of pressure vessels, boilers and pipes. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- Boiler steel 13CrMo4-5, 15CrMo5, 16CrMoV4, A 333 Grade P 11, P 12, G-17CrMo5-5, 22Mo4, G-22CrMo 5-4, 42CrMo4,
- Heat treatable steels up to 780 MPa tensile strength
- Case hardening and nitriding steels

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Mo
0,09	0,55	0,55	1,35	0,50

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 510	≥ 620	≥ 24	20°C ≥ 120

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
2,4	1000	5