

5CrMo**TIG (GTAW)****5%Cr-1/2Mo CREEP RESISTING STEEL TIG WIRE****PRODUCT DESCRIPTION**

Solid wire for TIG alloyed with 5%Cr-1/2Mo.

CLASSIFICATIONS

AWS A5.28M ER80S-B6
ISO 21952-A W CrMo5Si

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No 5

WELDING POSITIONS (ISO/ASME)

PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu	V
Min.	0.03	0.40	0.30	--	--	5.5	0.50	--	--	--
Max.	0.10	0.70	0.50	0.020	0.020	6.0	0.65	0.30	0.3	0.03
Typical	0.07	0.5	0.4	0.01	0.01	5.7	0.55	0.1	0.2	0.02

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.	Typical	
		745°C/1h	740°C/2h
Tensile strength (MPa)	590	640	570
0.2% proof strength (MPa)	470	530	440
Elongation [%] 4d	17	28	25
5d	17	25	20
Reduction of area %	--	72	78
Impact ISO-V(J) +20°C	--	240	--
Hardness cap/mid	--	195/215	--

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	140A, 14V

* Argon is also required as a purging gas for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	T5CRMO-16
2.4	5	PE TUBE	T5CRMO-24
3.2	5	PE TUBE	T5CRMO-32

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.