

Classifications				
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 in %				
C	Si	Mn	Cr	Mo
0,10	0,60	1,00	1,10	0,50
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)				
Rod diameter x length [mm]	Current type		Shielding gas	
2,0 x 1000	DC (-)		I 1	
2,5 x 1000	DC (-)		I 1	
3,2 x 1000	DC (-)		I 1	