

Classifications						
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 und 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						
Heattreatment	Shielding gas	0.2%-Yield strength	Tensile strength	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact values CVN	
		MPa	MPa	%	J	
A	M21*	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)						
Wire diameter [mm]	Current type		Shielding gas (EN ISO 14175)			
0.8	DC (+)		M1	M2	M3	C1
1.0	DC (+)		M1	M2	M3	C1
1.2	DC (+)		M1	M2	M3	C1
Other spool types on request.						