

MIGWELD CrMo

MIG/MAG Wires [GMAW]

Creep resistant steels

CLASSIFICATION: EN ISO 21952-A : G CrMo1Si DIN 8575 : SG CrMo1 AWS A-5.28 : ER 80S-G	APPROVALS: UDT, TUV	APPLICATION: Power generation industry Hardfacing and repairing Constructions & Engineering Petrochemical and chemical industry
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- Solid wire with Cr and Mo for welding steels working in temperature up to 550°C.
- For welding creep resistant steels working under pressure.
- Low Bruscato factor: X < 10ppm.

Application

Energy steels

Base material

13CrMo4-5	1.7335
15CrMo5	1.7205
42CrMo4	1.7225
16CrMoV4	1.7728
25CrMo4	1.7218
24CrMo5	1.7258
G22CrMo5-4	1.7354
G17CrMo5-5	1.7357
14CrMo4-5	
16MnCr5	
Tool steels	
ASTM A193 Gr. B7; A335 Gr. P11 a. P12; A217 Gr. WC6	
P11, P12	

Typical chemical composition %

C	Si	Mn	Cr	Mo
0,10	0,60	1,0	1,2	0,50

Typical mechanical properties

Yield strength Re [N/mm²]	>355
Tensile strength Rm [N/mm²]	>510
Elongation A5 [%]	>20
Impact energy Kv [J]	>47] (-10°C) /
Heat treatment	Annealing: 720°C/30 min, furnace cooling to 300°C, then in air
Additional description	X Factor: max. 15 ppm
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO ₂ /

Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
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1,0	80-95	17-19 short arc	15,0
1,0	240-270	24-27 spray arc	15,0
1,2	110-130	18-20 short arc	15,0
1,2	270-320	27-32 spray arc	15,0

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