# TIG welding rods for mild and low alloyed steel



WSG CrMo 1				
Classification DIN EN ISO	Classification AWS			
21952-A WCrMo1Si	A5.28 ER80S-G			
Approvals	Material No.			
TÜV 04293.06, CE, DB 42.045.13	1.7339			

## Characteristics and application

TIG/GTAW rod for high temperature creep resistant 1.25%Cr0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries. The wire has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications.

#### Base materials

For matching 1.25%Cr0.5%Mo creep resisting ferritic steels. 13CrMo 4-4, 13CrMo 4-5, 16CrMo 4-4, GS-17CrMo 5-5 ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12

#### Typical analysis in %

С	Si	Mn	Cr	Мо
0,10	0,60	1,00	1,20	0,52

#### Typical heat treatment

Preheat temperature: 200°C Interpass temperature: max. 300°C PWHT: 620-690°C

### Mechanical properties of the pure weld metal

Yield strength	Tensile strength	Elongation	Charpy-V-Value
in Mpa	in Mpa	in %	(ISO-V) in J
≥ 355	≥ 510	4d/5d: ≥22	RT ≥ 100 -40°C ≥ 47