

**TIG wire and rod for 1.25%Cr-0.5%Mo steel**

**Features:** • Applied for ASTM A387 Gr.11, Gr.12 and equivalents  
**Classification:** AWS A5.28 ER80S-G  
**Shielding Gas:** Ar  
**Identification color:** 1st Silver  
**Polarity:** DCEN

**Packaging data**

φ mm	Spool			Coil	Tube		
	kg			kg	kg	Length mm	g/piece
0.8	1	5	10	-	-	-	-
1.0	-	5	10	-	-	-	-
1.2	-	-	10	-	5	1,000	9
1.6	-	-	10	-	5	1,000	16
2.0	-	-	-	-	5	1,000	25
2.4	-	-	-	-	5	1,000	35
3.2	-	-	-	25kg	5	1,000	63
<b>Volume mm</b>	280W, 110H, 280L/10pcs	240W, 110H, 230L	430W, 90H, 430L		40W, 35H, 1015L		

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.05~0.12
<b>Si</b>	0.52	0.30~0.70
<b>Mn</b>	1.06	0.80~1.20
<b>P</b>	0.006	0.025
<b>S</b>	0.007	0.025
<b>Ni</b>	0.02	0.20
<b>Cr</b>	1.40	1.00~1.50
<b>Mo</b>	0.55	0.40~0.65
<b>Cu</b>	0.20	0.35

Note: <sup>a</sup>Single values are maximum.

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	634	469min.
<b>TS (MPa)</b>	735	552min.
<b>El on 4d (%)</b>	28	19min.
<b>IV -20°C (J)</b>	210	-
<b>PWHT (°Cx h)</b>	620x1	620±15x1

**Approvals**

<b>ABS</b>	MG
<b>LR</b>	MG (ER80S-G)
<b>DNV</b>	MG
<b>BV</b>	UP (ER80S-G)
<b>NK</b>	MG (ER80S-G)
<b>KR</b>	MG (ER80S-G)