

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

**Features:**                   • Applied for ASTM A213 Gr.11 and equivalents  
**Classification:**        AWS A5.28 ER80S-B2  
**Shielding Gas:**         Ar  
**Identification color:** 1st Silver  
**Polarity:**                 DCEN

**Packaging data**

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

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.07~0.12
<b>Si</b>	0.52	0.40~0.70
<b>Mn</b>	0.60	0.40~0.70
<b>P</b>	0.004	0.025
<b>S</b>	0.007	0.025
<b>Ni</b>	0.03	0.20
<b>Cr</b>	1.35	1.20~1.50
<b>Mo</b>	0.52	0.40~0.65
<b>Cu</b>	0.15	0.35

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

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	490	469min.
<b>TS (MPa)</b>	625	552min.
<b>El on 4d (%)</b>	32	19min.
<b>IV -20°C (J)</b>	246	-
<b>PWHT (°C×h)</b>	620×1	620±15×1