

S1 CrMo5

CATEGORY SAW Arc Submerged

PROPERTIES Submerged arc welding (5% chromium wire) for high temperature creep resistant steels

CLASSIFICATION

AWS	A 5.23: EB6
EN ISO	24598-A-S S CrMo5
DIN: W.Nr.	1.7374
DIN	8575:

SUITABLE FOR X12CrMo5, GX12CrMo5
 ASTM: A182/A336 grade F5, A199/A213 grade T5, A217 grade C5, A234 grade WP5, A335 grade P5, A387 grade 5

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr
0.08	0.50	0.30	6.0

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW							
SR	>470	>590	>17				

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing kg / spool
	Voltage (V)	Current (A)	
3,2			25
4,0			25
4,8			25

REDRYING TEMPERATURE Not required