

SG CrMo1

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| CATEGORY | GMAW-GTAW Solid wires |
| TYPE | Copper coated welding wire for welding creep and hydrogen-resistant steels. |
| APPLICATIONS | High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc. |
| PROPERTIES | Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas. Suitable to offer creep resistance for working temperatures up to 550° Celsius. |

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| CLASSIFICATION | AWS | A 5.28: ER 80S-G |
| | EN ISO | 21952-A: G CrMo1Si |
| | DIN: W.Nr. | 1.7339 |
| | DIN | 8575: SG CrMo1 |

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| SUITABLE FOR | 13CrMo4 5 (1.7335), 15CrMo5, 16CrMoV4, 22Mo4, G22CrMo5 4 (1.7354) G17CrMo5 5 (1.7357) A193 Grade B7, A335 Grade P11, A335 Grade P12, 42CrMo4 (Rm < 780 Mpa), 13CrMo44, 24CrMo5, 13CrMo4-5, A 387, Gr. 11 - 12, GS 17CrMo55, GS 22CrMo54, G17CrMo5-5, G22CrMo5-4 |
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| APPROVALS | CE approved |
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| WELDING POSITIONS: |  |
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| WELD METAL ANALYSIS % | C | Mn | Si | Cr | Cu | Mo |
| | 0.09 | 1.00 | 0.60 | 1.15 | < 0.25 | 0.50 |

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| MECHANICAL PROPERTIES | Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A5 (%) | Impact Energy (J) ISO-V 20°C -40°C | Shield gas En 439 | Hardness HRc / HV |
| | SR | > 450 | > 560 | > 22 | > 80 | M21 | |

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| WELDING PARAMETERS PACKING | Welding Parameters | | | Packing | | |
| D (mm) | Voltage (V) | Current (A) | spool type | kg / spool | kg / pallet | |
| 0.8 | | | KD-300 / Drum | 15 / 250 | 1080 / 1000 | |
| 1.0 | | | KD-300 / Drum | 15 / 250 | 1080 / 1000 | |
| 1.2 | | | KD-300 / Drum | 15 / 250 | 1080 / 1000 | |

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| REDRYING TEMPERATURE | not required |
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