MIG-LANKA CrMo1 1,0MM/15KG ER80S-G/B2 ITALFIL



Tuote	
Tuotekoodi:	ITCM1015
Viivakoodi:	9648000000005

Tekniset tiedot	
Paino:	1 kg

Vastaa esim. Lincoln LNM 19, ESAB 13.12 hitsauslankoja.

SFA-AWS A5.28 ER80S-G
EN ISO 21952-A- G/W CrMo1Si

Average Chemical analysis

C%	Si%	Mn%	P%	S%	Cu%	Cr%	Ni%	Mo%	Al%	V%	Zr+Ti%	Nb%
0,090	0,65	1,05	< 0,012	< 0,015	< 0,25	1,15	< 0,15	0,50	< 0,020	< 0,030	< 0,15	< 0,010

The copper value include the surface coating

Typical mechanical properties of all-weld metal

Rm	Rs	Al	Kv
N/mm²	**N/mm²**	**%5d**	**+20°C**
630	520	23	100 J

The mechanical properties are approximate and may range on the basis of the Heat, shielding gas, welding parameters and other factors

Welding process

Protection	MIG: C1, M21 and similar/ TIG: I1 (Argon)
Current and polarity	MIG: DC+ / TIG: DC-
Welding positions	EN ISO 6947: PA, PB, PC, PD, PE, PF, PG

Dimensions

MIG (mm)	0,60 - 0,80 - 0,90 - 1,00 - 1,14 - 1,20 - 1,40 - 1,60
TIG (mm)	1,00 - 1,20 - 1,60 - 2,00 - 2,40 - 3,00 - 3,20 - 4,00

BASE MATERIALS TO BE WELDED	13CrMo4-5, 15CrMo5, 16CrMoV4, G17CrMo5-5, G22CrMo5-4 A193 Gr.B7, A355 P11-12, A193: B7 13CrMo4-5, 15CrMo3, 13CrMo44, 15CrMo3, 13CrMo4 2, GS-25CrMo 4, GS-17CrMo55, GS17CrMo55, GS22CrMo4 H IV, 15CrMo3, 13CrMoV42, 13CrMo44, St44KL
APPLICATIONS	For heat resistant steels. It grants good resistance to hydrogen and sulphured agents attack. Used for steam boilers, pressure tanks, pipelines, cranes, ground moving machines, presses, chemical and petrolchemical industry.
APPROVALS	Contact ITALFIL