

## MIG-LANKA CrMo1 1,2MM/15KG ER80S-G/B2 ITALFIL



### Tuote

Tuotekoodi: ITCM1215  
Viivakoodi: 9647000000008

### 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/mm <sup>2</sup> | N/mm <sup>2</sup> | %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

