

## TIG-LANKA CrMo1 2,4MM/5KG ER80S-G/B2 ITALFIL



### Tuote

Tuotekoodi: ITCM24  
Viivakoodi: 9650000000008

### Tekniset tiedot

Paino: 1 kg

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

