

Standards

TS EN ISO 21952-A	: W Z Cr Mo1Si
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AWS A5.28	: E80C-B2(mod.)

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Mo	Cr
0.06	0.55	0.90	0.50	1.0

Mechanical Properties - (Typical)

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation ((L ₀ =5d ₀) (%))
680°C / 2h	min. 355	min. 550	min. 47 J	min. 20

Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 42CrMo4, 16CrMoV4, 25CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5

Features and Applications

- Recommended for welding of Cr-Mo alloyed steels which are used for the production of boilers, tubes, pipes and nitride steels
- Weld metal is resistant to temperatures up to +570°C
- Suitable for step-cooling applications
- Shielding Gas: 100% Argon

Welding Positions



Current Type

TIG D.C (-)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)
3010600001	2.40x1000	3/32x39"	5

Approvals: CE, SEPRO