SG CrMo 1 Si

Standards

TS EN ISO 21952-A	: G CrMo 1 Si
EN ISO 21952-A	: G CrMo 1 Si
TS EN ISO 21952-A	: W CrMo 1 Si
EN ISO 21952-A	: W CrMo 1 Si
AWSA5.28	: ER 80 S-G

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.10	0.6	1.0	0.5	1.2

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%))	Heat Treatment
min. 470	550 - 670	min. 47 J	min. 20	680°C/1hour-300°C air

Typical Base Material Grades

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

Features and Applications

- Used for the welding of high heat resisting. Cr-Mo alloyed steels which are used for the production of boilers tubes and pipes and nitrided steels
- Weld metal is resistant to temperatures up to +570°C
- Shielding gases: MAG; Ar+CO_2 and Ar+O_2 mix gases, TIG; pure Ar gas can be used

Welding Positions

Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010201969	3010201992	0.8	0.030”	15	D 200
3010201971	3010201994	1.0	0.040”	15	D 100
3010201973	3010201996	1.2	0.047”	15	ECO PACK
3010201974	3010201998	1.6 (0,6,0.9, 1.14,1.4)	0.062”	15 (1,5,15,18,50,250,400)	BIG PACK
3010300360		1.6 x 1000	1/16 x 39”	5	Carton Box
3010300361		2.0 x 1000	5/64 x 39”	5	
3010300362		2.4 x 1000	3/32 x 39”	5	
3010300363		3.2 x 1000	1/8 x 39”	5	
3010300364		4.0 x 1000	5/32 x 39”	5	

Approvals: CE, SEPRO