

**Standards**

TS EN ISO 21952-A	: G / W CrMo 5 Si
EN ISO 21952-A	: G / W CrMo 5 Si
AWS A5.28/(A5.9)	: ER 80 S-B6

**Chemical Composition of  
Welding Wire % (Typical)**

C	Si	Mn	Mo	Cr
0.07	0.45	0.5	0.6	6.0

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Heat Treatment
min. 470	min. 590	min. 70 J	min. 18	730-760°C/1h/300°C air

**Typical Base Material Grades**

- X12CrMo5, GX12CrMo5

**Features and Applications**

- Used for the welding of high heat resisting steels, hot hydrogen plants, working temperature is +600°C and also used for the welding of steels with 5 Cr 1/2 Mo
- Shielding gases: TIG: pure Ar gas can be used. MAG; Ar+CO<sub>2</sub>, and Ar+O<sub>2</sub> mix gases 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
<b>BS 300</b>	<b>D 300</b>				BS/D/300
3010202617	3010202640	0.8	0.030"	15	D 200
3010202619	3010202642	1.0	0.040"	15	D 100
3010202621	3010202644	1.2	0.047"	15	EGO PACK
3010202622	3010202646	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1,14,1,4)		(1,5,15,18,50,250,400)	
	3010300404	1.6 x 1000	1/16 x 39"	5	Carton Box
	3010300405	2.0 x 1000	5/64 x 39"	5	
	3010300406	2.4 x 1000	3/32 x 39"	5	
	3010300407	3.2 x 1000	1/8 x 39"	5	
	3010300408	4.0 x 1000	5/32 x 39"	5	

**Approvals:** CE, SEPRO