



MIG F60

Old reference: MIG 80SD2

Classification

AWS A5.28 : ER80S-D2

ISO 14341-A : G4Mo

Description & Applications

Copper coated solid wire for GMAW -alloyed with Mo- for welding creep resisting steels used at temperatures up to 500°C. Good resistance to Hydrogen attacks (chemical installations). Used for piping systems, boilers...

Base materials:

Steels and pipes for boiler and pressure vessels:

NF A 36-206	: 15D3 - 18MD4 -05
DIN 17155-17245	: H1 - H111 - GS C 25 17 Mn4
DIN 17175-17102	: 19Mn5 - 15Mo3 - GS22Mo4 St35,8 – St 45,8 - 17Mn4 - 19Mn5 - 15Mo3 - StE255 - StE420
BS	: BS 1504 Gr 245 BS 3100 Gr B1 BS 3606 Gr 243,245
ASTM	: A335 Gr P1 - A352 GrLC1 - A204 GrA and B-A 155 Gr CM 65/70

Typical Chemical Composition (%)

C	Si	Mn	Mo	Cu	P	S	Fe
0.08	0.7	1.8	0.5	0.2	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
500	620	25	+20°C 140
After PWHT 650°C/1h			

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	150-170	25-28	EN 439: M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	1.2	180-250	26-28	

Ind.10



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