



MIG F63G

Classification

AWS A5.28 : ER80S-G

ISO 21952-A : G CrMo1Si

Description & Applications

Copper coated solid wire for gas (Ar + CO₂) metal arc welding of creep resistant steels alloyed with Chromium and Molybdenum (1.25% Cr - 0.5% Mo) applied at service temperature up to 550°C.

Main applications: Petrochemical industry, chemical industry.

Base material :

Creep resisting steels:

EN	ASTM
13CrMo 4-5	A 182 gr F11, F12
25CrMo4	A 199 gr T11
14CrMo 4-5	A 200 gr T11
	A 213 gr T11, T12
	A 217 gr WC6, WC11
	A 234 gr WP11, WP12
	A 335 gr P11, P12
	A 377 gr 11, 12

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	V	P	S	Fe
Min	0.08	0.50	0.80	0.90		0.40						
Max	0.14	0.80	1.20	1.30	0.30	0.65	0.3	0.01	0.03	0.020	0.020	Rem.
Type	0.10	0.60	1.1	1.2	0.03	0.50	0.12	0.005	0.01	0.01	0.01	Rem.

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	355	550	20	+20°C 47
Max				
Type	550	620	26	+20°C 70

* After PWHT at 690°C/1h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	1.0	80 - 260	17 - 32	ISO 14175: M22 (Ar/CO ₂) 12-15 l/min
	1.2	100 - 360	18 - 34	

Preheating and interpasses temperature: 150-250°C

FT En-MF05-170303

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