MIG F69

Old reference: MIG CrMo5

Classification

ISO 21952-A : G CrMo5Si
AWS A5.28 : ER80S-B6
AWS A5.9 : ER502

Description & Applications

Copper coated solid wire for GMAW to weld creep resistant steels such as XC18S, E26, E36, X12CrMo5 (1.7362), ASTM A217 grade C5, ASTM A335 grade P5 used in the chemical industry and in thermal power plants.

Main applications: High temperature heat exchangers, piping systems…

Base material: **Pipes and steels for boiler and pressure vessels :**

EN	:	17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5
N° d'alliage	:	1.7332 ; 1.7362 ; 1.7363
ASTM	:	A387 Gr 5Cl1 et 2 – A199 Gr T5 – A182 Gr F5 – A213 G T5 A335 Gr P5 – A336 Gr F5 – A369 GrF5 – A217 Gr C5
EN	:	17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.08	0.4	0.5	5.6	0.1	0.55	0.15	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)
500	620	20

After PWHT 730°C/2h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2 1.6	150-170 150-220 190-300	25-28 26-28 26-32	EN 439: M21 (Ar/CO_2) 18 l/min

Ind.10

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