Selectarc WELDING

SELECTARC TIG F60

Old reference : TIG 80SD2

Classification

AWS A5.28 : ER80S-D2
ISO 636A : W4Mo
AIR 9117 : 8CrMo12

Approvals : CE

Characteristics

Solid copper coated wire electrode for GTAW alloyed with Mo for welding creep resisting steels used at temperature upto 500°C. Good resistance to Hydrogen attacks (chemical installations).

Applications

Used for Piping systems, Boilers, Steels and Pipes for boiler and Pressure Vessels:

Base Materials

NF A 36-206	15D3 - 18MD4 - 05
DIN 17155 - 17245	HI -HII - GS C 25 17 Mn4
DIN 17175 - 17102	19 Mn5 - 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 Gr. L C1-A204 Gr. A and B -A 155 Gr. CM 65/70

Typical Weld Metal Composition (%)

C	Si	Mn	Mo	Cu	P	S	Fe
0.08	0.70	1.80	0.50	0.20	0.020	0.018	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Re (MPa)	% Elg A_5	Impact (KV) Temp. °C	J
PWHT	630	550	25	+ 20	140

PWHT : After heat treatment at 650°C/1hr

Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back shielding : N_2 / H_2 : 3 - 6 l/min

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