



# TIG F63

Old reference: TIG 80SB2

## Classification

AWS A5.28 : ER80S-B2  
 ISO 21952-A : W Z CrMo1Si

Material N° : 1.7339

## Description & Applications

GTAW rods to weld heat and creep resistant Cr/Mo steels applied at service temperatures up to 550°C.

**Main applications:** petrochemical industry, chemical industry.

### Base materials:

### Steels and pipes for boiler and pressure vessels:

NF A 36-206	:	15D3 - 18MD4 -05 -15CD2.05 - 15 CD4.05
DIN 17155	:	13 CrMo 4.4 - 15CrMo3 - 13CrMoV42
DIN 1681	:	GS 22 CrMo5.4 – GS 22 Mo4
ASTM	:	A537 - A299 A355 GrP11 u. P12

### Heat treatable steels:

NF A 35-551	:	18CD4 - 16CM5
NF A 35-552	:	25CD4
DIN 17210	:	25CrMo4

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Mo	Cu	P	S	Fe
0.1	0.5	0.6	1.3	0.5	0.2	<0.02	<0.01	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	KV ( J )
490	590	25	+20°C 200

After PWHT at 700°C/1h

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Nitrogen / H <sub>2</sub> : 3-6 l/min

ind.10



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