



# TIG F69

Old reference: TIG CrMo5

## Classification

AWS A5.9 : ER502

ISO 21952-A : W CrMo5Si

AWS A5.28 : ER80SB-6

## Description & Applications

GTAW rod for welding of creep resisting steels used in the chemical industry and in thermal power plants. Good resistance against steam and hot gases.

**Main applications:** High temperature exchangers, piping...

### Base materials:

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

EN	:	17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5
Mat. N°	:	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 at 730°C/2h		

## 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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