

# CARBOFIL CrMo5

## TOP FEATURES

- Used in the chemical industry and in ammonia synthesis processes.
- Ideal for elevated temperature creep resisting steels
- Suitable for low temperature applications.

## TYPICAL APPLICATIONS

- Power Generation
- Petrochemical

## CLASSIFICATION

AWS A5.28	ER80S-B6
EN ISO 21952-A	G CrMo5Si

## SHIELDING GASES (ACC. EN ISO 14175)

M20	Mixed gas Ar+ 5-15% CO <sub>2</sub>
M21	Mixed gas Ar+ 15-25% CO <sub>2</sub>
M24	Mixed gas Ar+ 5-15% CO <sub>2</sub> + 0,5-3% O <sub>2</sub>
M26	Mixed gas Ar+ 15-25% CO <sub>2</sub> + 0,5-3%O <sub>2</sub>

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Mo
0.07	0.5	0.5	≤0.020	≤0.020	5.70	0.6

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	M21	PWHT 760°C/1h	≥470	≥590	≥17	≥47

\*PWHT = Post Welding Heat Treatment

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000282968

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.