5CrMo TIG

TOP FEATURES

- Developed for 5%Cr-0.50%Mo creep resisting steels
- Designed for high strength and improved corrosion resistance with hot hydrogen gas, super-heated steam, and Sulphur crude oil
- Weld metal chemistry is low in impurity elements allowing it to respect the X Factor (<120ppm)

CLASSIFICATION

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

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

TYPICAL APPLICATIONS

- Boiler Superheaters
- Piping
- Heat Exchangers
- Pressure vessels
- Nitriding

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu	V
Typical	0.07	0.5	0.4	0.01	0.01	5.7	0.55	0.1	0.2	0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Temperature	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Reduction of area (%)	Impact ISO-V (J) +20°C	Hardness, cap/mid (HV)
					4d	5d			
Required: AWS A5.28			470	590	17	17	-	-	-
Typical values	PWHT	745°C	530	640	28	25	72	240	198/215
	PWHT	740°C	440	570	25	20	78	-	-

PWHT = Postweld Heat treatment 1h

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	5.0	T5CRMO-24

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 for any updated information.