

CARBO S-G CrMo 5

CARBO T-G CrMo 5

International standards

	S = solid wire	T = bare rod
Material No.	1.7373	
EN 12070	G CrMo 5 Si	W CrMo 5
AWS SFA-5.28	ER 80 S-B6	ER 80 S-B6
AWS SFA-5.9	ER 502	ER 502

Approvals

Application notes

Copper coated wire electrode for high temperature steels and steels for hot hydrogen service, particularly in oil refineries.
Preheating and interpass temperature should be in the range of 300°C-350°C.
Tempering at 730°C-760°C for min 1 hour followed by cooling down in furnace/air.

Operating temperature

up to + 600° C

Base materials

1.7362 12 CrMo 19 5
1.7363 GS-12 CrMo 19 5

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at 20° C
620	495	25	200

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Mo
0,08	0,4	0,5	5,8	0,6

Gas types EN 439

S = solid wire

M2, M3, C1

T = bare rod

I1

Current

= +

= -

Diameter mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
Welding amps (A) max.	130	190	250	320					

coils, weight

B300 15 kg.

10 kg.

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