

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 1 1.7363 GS-12 Cr	9 5 Mo 19 5								

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)		Tensile strength R _m N/mm ² 620		Yielding strength R _{p0,2} N/mm ²			Elongation A ₅ %		lmı I	Impact strength ISO – V J at 20° C	
				495			25			200	
Weld metal an	alvsis	С	Si	Mn	Cr	Мо					
(typical, wt %)		0,08	0,4	0,5	5,8	0,6					
		S = solid wire					T = bare rod				
Gas types EN 439		M2, M3, C1						11			
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						
	(A) max.	130	190	250	320						
coils, weight Rev. 001/13		B300 ²	15 kg.			1	0 kg.				

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.