Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.32

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Benjamin Mousa	skodcz	Per-Erik Andersson	EN006336	EN005660	2014-02-07	1 (2)

REASON FOR ISSUE

Others tot. clarified

GENERAL

A copper coated, low-alloyed, chromium-molybdenum (5% Cr, 0,5% Mo), rod for GTAW of creep resistant steels of similar composition. Also suitable in welding of high strength steels with a minimum yield strength less than 730 Mpa.

AWS have changed the classification for this product, earlier classification was A5.9 ER502.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (5 % Cr - 0.5 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 21952-A	W CrMo5Si
EN ISO 21952-B	W 55 5CM
SFA/AWS A5.28	ER80S-B6

APPROVALS

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.03	0.10
Si	0.30	0.50
Mn	0.40	0.70
P		0.020
S		0.020
Cr	5.5	6.0
Ni		0.3
Mo	0.50	0.65
Cu		0.35
Others tot		0.50

Comments:
Others tot. according to applicable AWS standard.

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	Ar (I1) AWS	Ar (I1) AWS		Ar (I1) EN	Ar (I1) EN	Ar (I1) EN	
	As welded	Stress relieved 745°C 1h		Stress relieved++ 730-760°C 1h	Stress relieved+ 730-760°C 1h	Stress relieved 730-760°C 1h	
Properties	**Typ**	**Min**	**Typ**	**Typ**	**Typ**	**Min**	**Typ**
Rp0.2 (MPa)	730	470	580	430	465	400	550
Rm (MPa)	900	550	680	477	527	590	640
A4-A5 (%)	22	17	22	19	18	17	23
Z (%)	77		80				
at 20°C (J)	100		230			47	250
at -20°C (J)	80		200				
at -29°C (J)	50		200				
	Comments: Tested at 20°C	Comments: Tested at 20°C		Comments: Tested at 450°C	Comments: Tested at 350°C	Comments: Tested at 20°C	

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.6	40	180	10							
2.0	60	200	10							
2.4	100	220	11							
3.2	130	250	12							

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)