

MIGWELD CrMo**MIG/MAG WIRES
(GMAW)****CLASSIFICATION:**

EN ISO 21952-A: G CrMo1Si
 DIN 8575: SG CrMo1
 AWS A-5.28: ER 80S-G

APPROVALS:

UDT
 TUV

DESCRIPTION:

- Solid wire with Cr and Mo for welding steels working in temperature up to 550°C.
- For welding creep resistant steels working under pressure.
- Low Bruscato factor: X < 10ppm.

APPLICATION:

Energy steels

BASE MATERIAL:

13CrMo4-5	1.7335
15CrMo5	1.7205
42CrMo4	1.7225
16CrMoV4	1.7728
25CrMo4	1.7218
24CrMo5	1.7258
G22CrMo5-4	1.7354
G17CrMo5-5	1.7357
14CrMo4-5	
16MnCr5	
Tool steels	
ASTM A193 Gr. B7; A335 Gr. P11 a. P12; A217 Gr. WC6	
P11, P12	

TYPICAL CHEMICAL COMPOSITION (%):

C 0,10 Si 0,60 Mn 1,10 Cr 1,20 Mo 0,50

TYPICAL MECHANICAL PROPERTIES:

Re: >355 N/mm²
Rm: >510 N/mm²
A5: >20%
Kv: >47J (-10°C)

X Factor: max. 15 ppm

Heat treatment:

Annealing: 720°C/30 min, furnace cooling to 300°C, then in air

Shielding gases acc. to EN ISO 14175:

M21: Ar + 15-25% CO₂

φ	Welding parameters			Packing
	Current [A]	Voltage [V]	Transfer	Weight of packet [kg]
1,0	80-95	17-19	short arc	15,0
1,0	240-270	24-27	spray arc	15,0
1,2	110-130	18-20	short arc	15,0
1,2	270-320	27-32	spray arc	15,0

RELATED PRODUCTS: BASOWELD CrMo, RUTWELD CrMo

GWAM wires for creep resistant steels

Read more about this product: <https://www.metalweld.pl/en/migweld-crmo>