

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:
I1 = Pure Ar

Fer SG CrMo1 is our solid wire for TIG welding low alloyed fine grain and creep resisting steels like 13CrMo4 5 up to a maximum operating temperature of 550°C. Typical applications include the construction of pressure vessels, boilers and pipes. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- Boiler steel 13CrMo4-5, 15CrMo5, 16CrMoV4, A 333 Grade P 11, P 12, G-17CrMo5-5, 22Mo4, G-22CrMo 5-4, 42CrMo4,
- Heat treatable steels up to 780 MPa tensile strength
- Case hardening and nitriding steels

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
B 19 CrMo	-	-	-	-	-

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,10	1,00	0,60	≤ 0,025	≤ 0,025	1,20		0,50				

Note: AWS spec. ER 80S-B2 Mn 0,40-0,70%

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 460	≥ 560	≥ 22	+20°C ≥ 100

Note: properties under pure Argon gas shielding

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
2,4	1000	5