MIG F63

Old reference: MIG 80SB2

Classification

ISO 21952-A G CrMo1Si
AWS A5.28 : ER80S-B2

Material N° : 1.7339

Description & Applications

Copper coated solid wire for GMAW -alloyed with Cr and Mo- for welding creep resisting steels with 1% Cr - 0.5% Mo. Resistant to high temperature up to 500-550°C. For piping systems, boilers, overheaters. Nice aspect of the weld bead.

Main applications: Petrochemical industry, chemical industry.

Base materials:

Steels and pipes for boiler and pressure vessels:		
NF A 36-206	:	15D3 - 18MD4 –05 -15CD2.05 - 15 CD4.05
DIN 17155	:	13 CrMo 4.4 - 15CrMo3 - 13CrMoV42
DIN 1681	:	GS 22 CrMo5.4 – GS 22 Mo4
ASTM	:	A537 - A299 A355 GrP11 u. P12
Heat treatable steels:		
NF A 35-551	:	18CD4 - 16CM5
NF A 35-552	:	25CD4
DIN 17210	:	25CrMo4

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Cu	Ni	P	S	Fe
0.09	0.6	0.6	1.3	0.5	0.2	0.03	0.01	0.01	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
480	580	23	+20°C 150

After PWHT 700°C/1h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2	150-170 180-250	25-28 26-28	EN 439: M21 (Ar/CO_2) 12-15 l/min

Ind.10



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