T Union GT ERB2

Low Alloyed Steel GTAW Rod/Wire

Classifications		
AWS A5.28	**EN ISO 21952-B**	**GB/T8110**
ER80S-B2	W 1CM	ER55-B2

Characteristics and typical fields of application

- GTAW rod for the welding of 1.25Cr-0.5Mo low alloyed and creep resistant steels.
- Suitable for welding of low alloyed and creep resistant steels in boiler, tank, and pipeline.
- Low impurity content of wire, suitable for step-cooling requirements of hydrogenation equipment.

Base materials

13CrMo 4-5(AISI/AWS A182-F11&F12), GS-22 CrMo5-4, A355 Gr.P11 及 P12

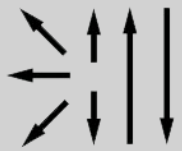
Typical analysis of all-weld metal (Wt.%)

	C	Si	Mn	P	S	Cr	Mo	Cu		
wt-%	0.098	0.55	0.60	0.006	0.002	1.26	0.50	≤0.10		

Mechanical properties of all-weld metal – typical values (min. values)

Condition	$R_{p0,2}$	R_m	A_4	K_V(J)
	MPa	MPa	%	-20 °C
690°C/1h	≥470	≥550	≥20	≥54
690°C/20h	310-550	515-620	≥22	≥54

Operating data



Polarity:	Size (mm)	Shielding gas: (ISO 14175)
DC -	2.0x1000 2.4x1000	I

Approvals

CE