

CARBO S- CrMo 1

CARBO T- CrMo 1

International standards

	S = solid wire	T = bare rod
Material-No.	1.7339	
EN 12070 :1999 ;	G CrMo 1 (Si)	W CrMo 1 (Si)
AWS A 5.28-05	ER 80S-G	ER 80S-G

Approvals

Application notes

Low alloyed, bright drawn wire for the manufacture of vessels, containers and pipelines for working temperatures up to 570°C. The alloy is suitable for heat treatable quenched and subsequently tempered steel as well as for tubes resistant to caustic embrittlements.

Operating temperature 20° C up to + 570° C

Base materials

1.7218 25CrMo4	1.7335 13CrMo4-5
1.7262 15CrMo5	1.7218 GS25CrMo4
1.7321 20MoCr4	1.7354 G22CrMo5-4

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at -40° C
700	480	20	80

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Mo
0,06	0,6	1,0	1,1	0,5

Gas types EN 439

S = solid wire

M2, M3, C1

T = bare rod

I1

Current

	= +				= -				
Diameter mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
Welding amps (A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

25 kg./ carton