

PRODUCT DATA SHEET

MIG/TIG B6



MIG/TIG B6 is a low alloy solid wire, with 5% Cr and 0,5% Mo, designed for welding creep resistant steels, for service temperatures up to 600°C. For welding ASTM A335 grade P5 and similar types that are employed in the chemical industry and in the ammonia synthesis process.

Classifications

AWS	A5.28	ER 80S-B6
EN	21952-A	G/W CrMo5Si
EN	21952-B	G/W 55 M 5CM (nearest)

Typical Chemical Analysis

% Carbon	0,07	% Sulphur	0,008
% Manganese	0,5	% Chromium	5,8
% Silicon	0,4	% Molybdenum	0,55
% Phosphorous	0,008	% Copper	0,10*

* For MIG 0,12%

Typical Mechanical Properties

	*MIG	*TIG
Tensile Strength	620 MPa	620 MPa
Yield Strength	500 MPa	500 MPa
% Elongation on 5d	25	25
Charpy V-Notch at +20°C	70 J	200 J

* After PWHT of 1 hour at 745°C

Packing Data MIG (DC+)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,0	230	25	15,0	W078322
1,20	280	26	15,0	W078324

TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078326
2,0	100	12	5,0	W078328
2,4	100	12	5,0	W078330

Suggested gas for welding: Argoshield® 5 or Stainshield® Plus (MIG), Argon (TIG)

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For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

