

MIG / TIG CrMo I



MIG/TIG CrMo I is a low alloy solid wire, with 1.2%Cr and 0.5% Mo, designed for welding low alloy steels and creep resistant steels, for service up to 500°C.

CLASSIFICATIONS

AWS	A 5.28	ER 80S-G
EN	12070	GCrMo I Si

CHEMICAL ANALYSIS

% Carbon	0.10	% Phosphorous	0.01
% Manganese	1.10	% Chromium	1.20
% Silicone	0.60	% Molybdenum	0.50
% Sulphur	0.01	% Copper	0.12

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED CONDITION)**

	*MIG	*TIG
Yield Strength	460 MPa	490 MPa
Tensile Strength	570 MPa	590 MPa
Elongation on 5d	23%	26%
Charpy V-Notch at 20°C	150J	250J

PACKING DATA

MIG (DC+)

Diameter (mm)	Current (A)		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.0	230	25	078-270	15
1.2	280	26	078-272	15

TIG (DC-)

Diameter (mm)	Current (A)		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.6	100	12	078-264	5
2.0	100	12	078-266	5
2.4	100	12	078-268	5

Recommended Shielding Gas Argoshield 5 (MIG), Argon (TIG)

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