

CARBO S- CrMo 1 CARBO T- CrMo 1

International s	S = solid wire T = ba						= bare ı	are rod				
		Material-No.			1.73				339			
		EN 12070 :1999 ;		; G	G CrMo 1 (Si)			W CrMo 1 (Si)				
		AWS A 5.28-05		E	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		1.721825CrMo41.733513CrMo4-51.726215CrMo51.7218GS25CrMo41.732120MoCr41.7354G22CrMo5-4										
Mechanical properties of all-weld-metal with Gas: M 21 (typical values)		Tensile strength R _m N/mm ²		Yield R _p	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 0,06	Si 0,6	Mn 1,0	Cr 1,1	Mo 0,5						
			S = so	lid wire	ire			T = bare rod				
Gas types EN 439		M2, M3, C			1				11			
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. (A) max.	80 130	120 190	180 250	250 320							
coils, weight Rev. 001/13		B300	15 kg.			2	5 kg./	carton				

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.