MIG F63

Old reference: MIG 80SB2

Classification

AWS A5.28 : ER80S-B2 ISO 21952-B : G 55 M22 1CM

Description & Applications

Copper coated solid wire for gas (Ar + O_2) metal arc welding of creep resistant steels alloyed Chromium and Molybdenum (1.25% Cr - 0.5% Mo) applied at service temperature up to 550°C.

Main applications: Petrochemical industry, chemical industry.

Base material :

Creep resisting steels:

EN	*ASTM*
13CrMo 4-5	A 182 gr F11, F12
25CrMo4	A 199 gr T11
14CrMo 4-5	A 200 gr T11
	A 213 gr T11, T12
	A 217 gr WC6, WC11
	A 234 gr WP11, WP12
	A 335 gr P11, P12
	A 377 gr 11, 12

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	O/T
Min	0.07	0.40	0.40	1.20		0.40				
Max	0.12	0.70	0.70	1.50	0.20	0.60	0.35	0.025	0.025	0.50
Type	0.09	0.60	0.60	1.3	0.03	0.50	0.15	0.01	0.01	<0.50

All Weld Metal Mechanical Properties*

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	470	550	19	-	-
Max					
Type	490	580	21	+20°C	150

* After PWHT at 620°C/1h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	1.0 1.2	80 - 260 100 - 360	17 - 32 18 - 34	ISO 14175: M22 (Ar/O_2) 12-15 l/min

Preheating and interpasses temperature: 135-165°C

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