



MIG F69

Old reference: MIG CrMo5

Classification

AWS A5.28 : ER80S-B6

ISO 21952-A : G CrMo5Si

Description & Applications

Copper coated solid wire for gas (Ar + O₂) metal arc welding of creep resistant steels alloyed Chromium and Molybdenum (5% Cr – 0.5% Mo) applied at service temperature up to 600°C.

Main applications: High temperature exchangers, piping, steam boilers, pressure vessels...

Base material :

Creep resisting steels:

EN	ASTM
X12CrMo5	A 182 / A 336 gr F5
G-X12CrMo5	A 199 / A 213 gr T5
	A 217 gr C5
	A 234 gr WP5
	A 335 gr P5
	A 387 gr 5

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	V	P	S	O/T
Min	0.03	0.30	0.40	5.5		0.50						
Max	0.10	0.50	0.70	6.00	0.30	0.65	0.3	0.01	0.03	0.020	0.020	0.50
Type	0.08	0.40	0.50	5.6	0.10	0.55	0.15	0.005	0.01	0.01	0.01	<0.50

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	470	590	17	+20°C >47
Max				
Type	500	620	20	+20°C 100

* After PWHT at 745°C/1h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	1.0	80 - 260	17 - 32	ISO 14175: M22 (Ar/O ₂) 12-15 l/min
	1.2	100 - 360	18 - 34	
	1.6	130 - 450	19 - 38	

Preheating and interpasses temperature: 200-230°C

FT En-MF09-1911103

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