



# TIG F63

Old reference: TIG 80SB2

## Classification

AWS A5.28 : ER80S-B2

ISO 21952-B : W 1CM

## Description & Applications

Copper coated solid rod for GTAW of creep resistant steels alloyed with 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	V	P	S
Min	0.07	0.40	0.40	1.20		0.40				
Max	0.12	0.70	0.70	1.50	0.20	0.65	0.35	0.03	0.025	0.025
Type	0.09	0.50	0.60	1.3	0.03	0.50	0.20	0.01	0.01	0.01

## All Weld Metal Mechanical Properties\*

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	470	550	19	+20°C 47
Max				
Type	490	590	25	+20°C 200

\* After PWHT at 620°C/1h

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar): 6-12 l/min Back shielding : I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

Preheating and interpasses temperature: 135-165°C

FT En-TF03-190219

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