



# TIG F69

Old reference: TIG CrMo5

## Classification

AWS A5.28 : ER80S-B6

ISO 21952-A : W CrMo5Si

## Description & Applications

Copper coated solid rod for GTAW of creep resistant steels alloyed with Chromium and Molybdenum (5% Cr – 0.5% Mo) applied at service temperature up to 600°C.

**Main applications:** High temperature exchangers, piping system, 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
Min	0.03	0.30	0.40	5.50		0.50					
Max	0.10	0.50	0.70	6.00	0.3	0.65	0.3	0.01	0.03	0.020	0.020
Type	0.08	0.40	0.50	5.6	0.10	0.55	0.15	0.005	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	590	17	+20°C 47
Max				
Type	500	620	20	+20°C 160

\* After PWHT at 745°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: 200-230°C

FT En-TF09-190219

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