

TIG Rods C-Mn steels and low-alloy steels

Carborod CrMo1 is a TIG rod suitable for welding 1,25% Cr 0,5% Mo and 0,9% Cr 0,5% Mo steels. Excellent mechanical properties. The weld deposit is resistant to cold cracking.

Classification	
AWS	A5.28: ER 80S-G
EN	12070: W CrMo1 Si

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.20	0.60	≤ 0.020	≤ 0.020	1.20	-	0.06	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -29°C	Hardness
PWHT 690°C x 1h	≥ 355	≥ 550	≥ 20	≥ 70	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

Materials

13CrMo4-5, 13CrMoSi5-5; G17CrMo5-5

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	1,6	2,0	2,4	3,2		
------------------------	-----	-----	-----	-----	--	--

Further forms of delivery on request.