

标准 标号	AWS A5.28	EN ISO 21952-B	GB/T8110
	ER80S-G(ER80S-B2 mod.)	W 1 Cm1	ER55-G (ER55-B2mod.)

特性及应用范围

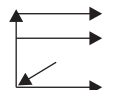
- 适用于1.25Cr - 0.5%Mo低合金耐热钢钨极氩弧焊；
- 适用于电站锅炉，压力容器，储罐，管线和核反应堆用耐热钢的钨极氩弧焊；
- 适用于电站锅炉水冷壁，压力容器，储罐，管线和核反应堆用低合金耐热钢的钨极氩弧焊；
- 超低杂质含量，可满足加氢设备步冷试验要求。

适用母材 13CrMo 4 - 5 (AISI/AWS A182 - F 11 & F 12); GS - 22 CrMo 5 - 4

焊丝 化学成分 (Wt. %)	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS	-	-	-	-	-	-	-	-	-	0.005	0.005	0.005
EN	0.08 0.14	0.50 0.80	0.80 1.20	- 0.020	- 0.020	0.90 1.30	0.40 0.65	- 0.30	- 1.30	-	-	-
典型值	0.09	0.35	0.65	≤0.010	≤0.010	1.20	0.50	≤0.10	0.04	≤0.005	≤0.005	≤0.005
X 系数	≤15ppm											

全焊缝金属 机械性能 (根据 AWS B4.0M)	焊后热处理 (°C/h)	保护 气体	R _{p0.2}		R _m		A ₄		K _v (J)	
			(MPa)	(MPa)	(%)	(%)	+20°C	-20°C		
AWS	620/1	I1	≥470	≥550	≥19	-	-	-	-	
EN	620/1	I1	≥470	≥550	≥20	≥47	-	-		
	690/1	I1	≥470	≥550	≥20	≥55	≥55	-		
保证值	690/4 ⁺²	I1	310-550	515-620	≥22	55	≥100	-		
	690/20 ⁺²	I1	310-550	515-620	≥22	55	55	-		

使用规范

适用焊接位置  电流极性: DC-
保护气体: 符合 EN 439 标准 I 类气体
焊丝标识: ※ W III

供货标准	产品编号	规格 (mm)	单位包装形式	单位包装重量 (Kg)
	67325	1.0	盘 (S300)	10.0
	67326	1.2	盘 (S300)	15.0
	69008	2.0x1000	盒	20.0
	69009	2.4x1000	盒	20.0

Specification Clas. Code	AWS A5.28	EN ISO 21952-B	GB/T8110
	ER80S-G(ER80S-B2 mod.)	W 1CM1	ER55-G (ER55-B2mod.)

Properties & Application

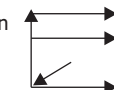
- GTAW rod for the welding of 1.25Cr-0.5Mo low alloyed and creep resistant steels.
- Suitable for welding of low alloyed and creep resistant steels in boiler, tank, and pipeline.
- Low impurity content of wire, suitable for step-cooling requirements of hydrogenation equipments.

Base Metals 13CrMo 4 - 5 (AISI/AWS A182 - F 11 & F 12); GS - 22 CrMo 5 - 4

Chemical Composition of Rod (Wt. %)	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS	-	-	-	-	-	-	-	-	-	0.005	0.005	0.005
EN	0.08 0.14	0.50 0.80	0.80 1.20	- 0.020	- 0.020	0.90 1.30	0.40 0.65	- 0.30	- 1.30	-	-	-
Typical	0.09	0.35	0.65	≤0.010	≤0.010	1.20	0.50	≤0.10	0.04	≤0.005	≤0.005	≤0.005
X-factor	≤15ppm											

Mechanical Properties of All Weld Metal (According to AWS B4.0M)	PWHT (°C/h)	Shield Gas	R _{p0.2}		R _m		A ₄		K _v (J)	
			(MPa)	(MPa)	(%)	(%)	+20°C	-20°C		
AWS	620/1	I1	≥470	≥550	≥19	-	-	-	-	
EN	620/1	I1	≥470	≥550	≥20	≥47	-	-		
Typical	690/1	I1	≥470	≥550	≥20	≥55	≥55	-		
	690/4 ⁺²	I1	310-550	515-620	≥22	55	≥100	-		
Guarantee	690/20 ⁺²	I1	310-550	515-620	≥22	55	55	-		

Operating Data

Welding Position  Polarity: DC-
Shielding gas: (EN 439) I
Wire Mark: ※ W III

Size & Packing	Product No.	Size (mm)	Pack	Kg/pack
	67325	1.0	Spool (S300)	10.0
	67326	1.2	Spool (S300)	15.0
	69008	2.0x1000	Box	20.0
	69009	2.4x1000	Box	20.0