

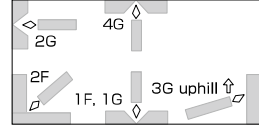
**Solid wire for 1~1.25%Cr-0.5%Mo steel**

**Features:**      ■ Applied for ASTM A387 Gr.11, Gr.12 and equivalents

**Classification:** AWS A5.28 ER80S-G

**Shielding gas:** Ar-2~5%O<sub>2</sub>, Ar-5~20%CO<sub>2</sub>

**Polarity:**        DCEP

**Welding Positions:****Packaging data**

φ mm	Spool		Drum		
	kg	kg	kg	kg	kg
0.8	10kg	-	-	-	-
0.9	10kg	-	-	-	-
1.0	10kg	20kg	-	-	-
1.2	10kg	20kg	250kg	300kg	400kg
1.4	10kg	-	-	-	-
1.6	-	20kg	-	-	400kg
<b>Volume mm</b>	240W, 110H, 230L	280W, 110H, 270L	530 φ, 820H		680 φ, 770H

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.12
<b>Si</b>	0.55	0.30~0.90
<b>Mn</b>	1.05	0.80~1.50
<b>P</b>	0.007	0.025
<b>S</b>	0.008	0.025
<b>Cr</b>	1.38	1.00~1.60
<b>Mo</b>	0.56	0.40~0.65
<b>Cu</b>	0.26	0.40

Note: <sup>a</sup>Single values are maximum.

**Welding parameters (A)**

φ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	240~300	130~190

**All-weld mechanical properties**

	Typical		Guaranty
	MPa	MPa	
<b>0.2%YS (MPa)</b>	550	570	469min.
<b>TS (MPa)</b>	640	680	552min.
<b>El on 4d (%)</b>	25	22	17min.
<b>IV 0°C (J)</b>	190	70	-
<b>PWHT (°Cxh)</b>	650x1	620x1	620±15x1
<b>SG</b>	Ar-2%O <sub>2</sub>	Ar-20%CO <sub>2</sub>	Ar-2%O <sub>2</sub>

**Approvals**

<b>ABS</b>	MG
<b>LR</b>	MG
<b>BV</b>	UP
	(AWS A 5.28 ER80S-G)
<b>NK</b>	MG