

XP CrMo1Si

CREEP RESISTANT



CLASSIFICATIONS

EN ISO 21952-A	AWS A5.28
G CrMo1Si	ER80S-G

KEY FEATURES AND APPLICATIONS

- 1.25% Cr, and 0.5% Mo alloyed wire intended for welding similar composition steels.
- Typically used for high-strength, creep-resistant low-alloy steel welding applications.
- The presence of molybdenum helps resist hydrogen attack in chemical process applications.
- Ideal for service temperature up to 550°C max.
- Commonly used on equipment in the chemical and ammonia synthesis process, heat exchangers, boilers, pipes and pressure vessels.

BASE MATERIALS

13CrMo4-5, 15CrMo5, 16CrMoV4, G17CrMo5-5, G22CrMo5-4 A193 Gr.B7, A355 P11-12, A193: B7 13CrMo4-5, 15CrMo3, 13CrMo44, 15CrMo3, 13CrMo4 2, GS-25CrMo 4, GS-17CrMo55, GS17CrMo55, GS22CrMo4 H IV, 15CrMo3, 13CrMoV42, 13CrMo44, St44KL

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Mo	Cu
MIN	0.08	0.50	0.80	-	-	0.90	0.40	-
MAX	0.14	0.80	1.20	0.020	0.020	1.30	0.65	0.35

Single values are maximum values according to EN ISO 21952

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
520	630	23	100	20°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15209	0.8	BS300	15	72
XP15212	1.0	BS300	15	72
XP15215	1.2	BS300	15	72

