TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP ER 80S-G (A32)

CREEP RESISTANT

CLASSIFICATIONS

EN ISO 21952-A	AWS A5.28
W 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	20ºC

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 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP15328	1.6	1000	5	PAP 20 Tube
XP15330	2.4	1000	5	PAP 20 Tube
XP15332	3.2	1000	5	PAP 20 Tube

MADE IN EU