



## AUTOTHERME Cr-Mo 1

**CODIFICATION:** AWS : SFA 5.28 ER80S-B2

### CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 1 is a copper-coated solid wire for GMAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is suitable for welding 1.25Cr-0.5Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes & tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F2, F11, F12 class 1 & 2 of SA-182, Grade T11 of SA-199, Grade T2, T11 & T12 of SA-213, Grade WC6 of SA-217, Grade P2, P11 & P12 of SA-335, Grade FP2, FP11 & FP12 of SA-369, Grade 2, 11 & 12 of SA-387, Grade CP2, CP11 & CP12 of SA-426, etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.08	0.50	0.55	0.010	0.012	1.30	0.55	0.1

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
620	550	24

### WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.20 mm	27-32	300-360
1.60 mm	25-30	340-420

**SHIELDING GAS :** Argon/ 1-5% O<sub>2</sub>

**WELDING POSITION :** H, F, VU, OH

**APPROVAL :** CIB-MP

### PACKING :

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

**Note :** Please check availability of drum packing before placing the order.