

## F Cr-Mo 5

**CODIFICATION:**                      **AWS :**    SFA 5.28 ER80S-B6

### **CHARACTERISTICS AND APPLICATIONS:**

F Cr-Mo 5 is a copper-coated solid wire for GTAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is suitable for welding 5Cr-0.5Mo steel. The weld metal possesses good high temperature properties. The weld metal possesses excellent creep property up to 550°C. Especially suitable for welding of pipes and tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F5/F5a & F21 of SA-182, Grade T4, T22 of SA-199, Grade T22 of SA-213, Grade C5 of SA-217, Grade P22 of SA-335, Grade F5 & F21 (class 1&3) of SA-336, Grade FP5, FP21 of SA-369, Grade 5, 21 & 21L of SA-387, Grade CP5, CP21 of SA-426, Class 4, 4a of E types of SA-542, etc.

### **TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.06	0.50	0.40	0.010	0.012	5.20	0.55	0.10

### **TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

**(PWHT: 745°C FOR 1 HR)**

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
600	520	25

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

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

### **PACKING:**

**STANDARD SIZE**                      Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

**QUANTITY**                              5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.

Identification AWS code is punched on each wire.