AMA 80-17 T

Standards: AWS / ASME SFA 5.28 E R 90S-B3
DIN 8575 SG CrMo 2

Application / Properties: GTAW rod for or Cr-Mo low alloyed boiler, plate and tube steels as well as in oil refineries. Preferably used for the base metal 10CrMo910 Approved in long-term condition up to +600 °C service temperature. Also for similar alloyed quenched and tempered steels and case hardening steels. The deposit is noted for its good mechanical properties and cracking resistance.

Analysis of Wire electrode % (Typical value):

C	Si	Mn	Cr	Mo
0.1	0.5	0.7	2.4	1

Shielding gas: DIN EN 439 - I1 (100% Ar)

Mechanical properties of all -weld metal:

Heat Treatment	Tensile Strengt (N/mm^2)	Yield Strength (N/mm^2)	Elongation A5 (%)	Impact energy (j) ISO - V +20 °C
T	580-700	>450	>20	150

T :Heat treatment 1 h at 745C,furnace cooling to 300C

Material:

DIN Standard 10CrMo9 10; 10CrSiMoV7; G17CrMo 910.

ASTM Standard ASTM A335 Gr. P22; A217 Gr. WC 9.

Delivery: Copper coated , welding rods

Weight: 5kg.

Diameter: 1-4 mm

Note: other weight & sizes are produced upon customers request.