

TIG Rods C-Mn steels and low-alloy steels

Carborod CrMo5 is a TIG rod suitable for welding creep resistant 5% Cr 0,5% Mo steels. Suitable for applications including chemical and ammonia synthesis plants.

Pre-heating and interpass temperatures in the range 250-300°C are recommended.

Classification	
AWS	A5.28: ER 80S-B6
EN	12070 W CrMo5 Si

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	0.50	0.50	≤ 0.020	≤ 0.020	5.70	-	0.60	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -29°C	Hardness
PWHT 760°C x 1h	≥ 470	≥ 590	≥ 20	≥ 60	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

Materials

12CrMo19-5, X12CrMo5; A182 Gr. F5, A199 Gr. T5, A213 Gr.T5, A335 Gr.P5

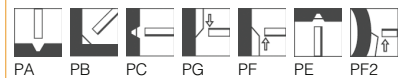
A 336 Cl. F5, A 369 Gr. FP5, A 387 Gr.5, Cl 1 and 2

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	2,0	2,4			
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Further forms of delivery on request.