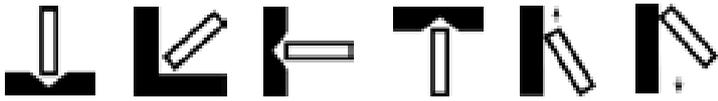


**Welding consumables GMAW solid wire electrode for:
creep resistant steels**

WDI CrMo1 SG • VDG CrMo1 • WEKO CrMo1

Standard designation	DIN EN ISO 21952 CrMo1 Si		AWS A 5.28 ER80 S-G			
Properties and application range	Welding wire for MAG-welding of creep resistant steels in a steam boiler, pressure vessel construction and pipeline construction, up to operation temperatures of 570°C. Also usable for the welding of steels that are resistant to caustic cracking.					
Materials being suitable for welding	DIN 17155 13 CrMo 4 4 EN 10028-2 13 CrMo 4 5 DIN 17245 GS-17 CrMo 5 5 StE 355 (H IV L) steel resistant to caustic cracking					
Reference analysis (%)	C 0,1	Si 0,6	Mn 1,0	Cr 1,1	Mo 0,5	
Mechanical performance according to EN 1597-1	post-weld heat treatment	inert gas	yield strength N/mm ²	all-weld metal tensile strength N/mm ²	elongation (L ₀ =5d ₀) %	energy absorbed ISO-V(Joule)
	U	C	420	470	20	80
	U	M2	450	500	20	90
Welding position						kind of current= + inert gas (EN 439) Argon mixed gas CO ²
Wire packaging	Spooling types see from page 78 wire diameter 0,8 - 1,6 mm other dimensions on demand					