



TIG/MIG Filler Wire

CrMo Steels

AWS A5.28: ER80S-G
BS 2901 Pt1: A32 (Obs.)
DIN 8575 W/MSG CrMo-1

CMW-1900

DESCRIPTION & APPLICATION

TIG/MIG Filler Wire for the joining or overlay of 1.25%/0.25% CrMo steels
Can be used also for the reclamation of Plastic mould steels such as BS P20.

BASE MATERIALS

BS EN 10083-1, 708M20, 708H20 EN 19A ASTM A335-92b, GRADE P11
ASTM A387-90a GRADE 11, 12 BS BP 20 Mould Steel

MECHANICAL PROPERTIES

550	560	19	-
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HB

METAL WELD COMPOSITION %

C	Si	Mn	Cr	S	P	Mo	Fe
0.11	0.75	0.4	1.25	0.02	0.02	0.5	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

1.6, 2.4, 3.2mm (TIG)
0.8, 1.0, 1.2mm (MIG)

WELDING INSTRUCTIONS

Preheat as per the requirements of the base material.

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Low Alloyed Steels