



AWS A5.29: ER502
BS 2901 Pt1: A34~ (Obs.)

TIG/MIG Filler Wire 5CrMo Steels

CMW-1930

DESCRIPTION & APPLICATION

TIG/MIG Filler Wire for the joining of 5 CrMo High Temperature Steels and steels for hot hydrogen service particularly in oil refineries. Service temperature up to 600°C.

BASE MATERIALS

K.R : 12 CrMo 19 5 W/No. 1.7362
G.GS-12CrMo 19.5 W/No. 1.7363
AISI/ASTM A213, A217 Gr C5, A335 Gr P5

MECHANICAL PROPERTIES

620 UTS n/mm	495 YIELD 0.2%	25 ELONG A5%	200 IMPACT (J) 920°C
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	S	P	Mo	Fe
0.08	0.4	0.5	5.8	0.02	0.02	0.6	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. (300-350°C). Maintain interpass temp at that level. Temper at 730-760°C for 1hour followed by cooling in furnace/air.