TG-S1CM TRUSTARC™

TIG wire and rod for 1.25%Cr-0.5%Mo steel

Features: ▪ Applied for ASTM A387 Gr.11, Gr.12 and equivalents

Classification: AWS A5.28 ER80S-B2Mn

Shielding Gas: Ar
Identification color: 1st Silver
Polarity: DCEN

Packaging data

	Spool			Coil	Tube		
ϕ mm	**kg**			**kg**	**kg**	**Length mm**	**g/piece**
0.8	1	5	10	-	-	-	-
1.0	-	5	10	-	-	-	-
1.2	-	-	10	-	5	1,000	9
1.6	-	-	10	-	5	1,000	16
2.0	-	-	-	-	5	1,000	25
2.4	-	-	-	-	5	1,000	35
3.2	-	-	-	25	5	1,000	63
Volume mm	280W, 110H, 280L/10pcs	240W, 110H, 230L		430W, 90H, 430L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.08	0.05~0.12
Si	0.52	0.30~0.70
Mn	1.06	0.80~1.20
P	0.006	0.025
S	0.007	0.025
Ni	0.02	0.20
Cr	1.40	1.00~1.50
Mo	0.55	0.40~0.65
Cu	0.20	0.35

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	630	469min.
TS (MPa)	740	552min.
El on 4d (%)	28	19min.
IV -20℃ (J)	210	-
PWHT (℃x h)	620x1	620±15x1

Approvals

ABS	MG (AWS A5.28 ER80S-G)
LR	MG
DNV	VL1Cr0.5Mo, MG
BV	UP (AWS A5.28 ER80S-G)
NK	MG (AWS A5.28 ER80S-G)
KR	MG (AWS A5.28 ER80S-G)