TG-S80B2 TRUSTARC™

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

Features: ▪ Applied for ASTM A213 Gr.11 and equivalents

Classification: AWS A5.28 ER80S-B2

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

Packaging data

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

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.10	0.07~0.12
Si	0.52	0.40~0.70
Mn	0.60	0.40~0.70
P	0.004	0.025
S	0.007	0.025
Ni	0.03	0.20
Cr	1.35	1.20~1.50
Mo	0.52	0.40~0.65
Cu	0.15	0.35

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	490	469min.
TS (MPa)	630	552min.
El on 4d (%)	32	19min.
IV -20℃ (J)	250	-
PWHT (℃xh)	620x1	620±15x1