

# TIGFIL 80SG

## Classification

AWSA/SFA 5. 28 : ER 80SG

**Identification:** AWS classification embossed at one end of the wire.

## Characteristics

A copper coated low alloy GTAW/TIG filler/rod with 1% Cr & 0.5% Mo. It is characterized by smooth flow and gives shiny welds of radiographic quality.

## Typical Applications

For welding of 1Cr-0.5Mo steels such as ASTM A-387 Gr. B, DIN steels, 15CrMo3, A-335 Gr. P11 etc.

### Wire Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr
0.08-0.12	0.80-1.20	0.50-0.80	0.020 max	0.020 max	0.40-0.60	1.00-1.30

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

### All Weld Mechanical Properties After PWHT of 620°C for 1 hr.

UTS MPa	550 min
Yield strength MPa	480 min
Elongation % (L=4xd)	22 min
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.	

### Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



WELDERS TO THE NATION SINCE 1951  
**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

[www.adorwelding.com](http://www.adorwelding.com)

