

## Key Facts

- Low alloy **Chrome-Moly 1** Gas Tungsten Arc Welding (GTAW) rod for welding of matching Chrome-Moly steels
- Low alloyed with a nominal 1-¼% Chromium and ½% Molybdenum addition to enable welding of selected low alloy, medium tensile strength steels and creep resistant steels
- Suitable for dissimilar welding of Chrome-Moly steels to Carbon Steels
- Supplied in a re-sealable heavy-duty cardboard tube

## Description

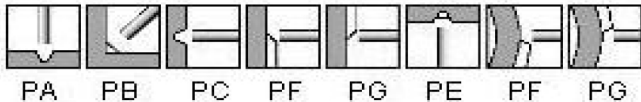
A low-alloy copper coated TIG filler rod with 1.25% Cr and 0.5% Mo content to be used for the welding of creep resistant steels. Also suitable for the welding of steels with 0.5-1.0% Cr and 0.5% Mo content.

## Classification, Approvals and Conformances

AS/NZS 1167.2: RB2  
ISO 21952-B: W 1CM  
**AWS A5.18: ER80S-B2**  
TUV: CERT No: 11377.0006.10 to EN ISO 21952-B: W 1CM

## Welding Positions

All positional, including vertical down.



## Recommended Shielding Gas

Welding Grade Argon 99.95%  
AS 4882-2003: SG-A ISO-14175-97: I1

## Markings & Identification

End stamped with AWS Class: ER80S-B2

## Applications

Used in the chemical and ammonia synthesis process industries, for heat exchangers, boilers, piping and pressure vessels for with service temperatures up to 550°C. **INETIG B2** also finds applications in the petrochemical industries, suitable for facing and build up on castings and for casting repairs.

## Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon	P - Phosphorus
0.080%	0.06%	0.60%	0.010%
S - Sulphur	Cu - Copper	Cr - Chromium	Mo - Molybdenum
0.010%	0.15%	0.30%	0.500%
Fe - Iron			
Remainder			

## Typical All Weld Metal Mechanical Properties

Yield Strength:	490 MPa
Tensile Strength:	590 MPa
Elongation (5xD):	25%
Typical Hydrogen	≤ 3ml/100g of deposited weld metal
Impact Strength Charpy-V	250J @ +20°C

## Packaging & Ordering Information

Size	Weight	Part Number
1.6mm	5Kg (CrMo-1)	300139
2.4mm	5Kg (CrMo-1)	300140