

MT- Cromo 1

1.7339

Low-alloy MIG/TIG wire of chrome molybdenum steel for welding heat and hydrogen resisting steels, suitable for working temperatures of up to +570° C°.

Standard designation

Material No.	1.7339
EN ISO 21952-A	G/W CrMo1Si
AWS/ASME SFA-5.28	ER 80 S-G

Main base metals

1.7335	13 CrMo 4 4	1.7218	GS - 25 CrMo 4
1.7357	GS - 17 CrMo 5 5	1.7350	22 CrMo 4 4
1.7337	16 CrMo 4 4	1.7354	GS - 22 CrMo 5 4
1.7218	25 CrMo 4	1.7225	42 CrMo 4

Mechanical properties of all – weld – metal (typical values)

Welding process Gas shield Thermal treatment Test temperature		[°C]	TIG I1 tempered		MIG M 11 tempered	
			+20°C	+550°C	+20°C	+550°C
0,2%-yield strength	R _{p0,2}	MPa	>355		>355	
Tensile strength	R _m	MPa	>510		>510	
Elongation	A ₅	[%]	>20		>20	
Impact strength	A _V	[J]	>47		>47	

Average chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Mo
0,08-0,14	0,5-0,8	0,8-1,2	0,9-1,3	0,4-0,65

Gas types applicable TIG Gas types applicable MIG

I1
C1, M 11-M 33

Approvals TIG Approvals MIG

TÜV, CE
TÜV, DB, CE

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box [kg]
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,20	1000	25,0

MIG welding wire

Diameter 0,8 mm 1,0 mm 1,2 mm 1,6 mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PC, PF

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PD, PE, PF

Current/Polarity TIG

= -

Current/Polarity MIG

= +