

# TALARC B6

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER80S-B6	EN ISO 21952-A: G CrMo5Si

## ALLOY TYPE

5Cr-0.5Mo content to be used for the welding of creep resistant steel.

## APPLICATIONS

Low alloy copper-coated solid wire with 5% Cr and 0.5% Mo content to be used for the welding of creep resistant steel. It will find applications in chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600°C. The weld metal has also been used for subsequent nitriding in the petro-chemical industries; for example in the repair of some steels used for moulds for injection-moulding of plastics. To be used under the shield of Ar+O<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.07	0.50	0.40	0.008	0.008	5.80	-	0.55	0.12

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-60°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
<b>MIX</b>	after PWHT	500	620	25	70	-	-	-	-

## WELDING GUIDELINES

Preheat and interpass temperature 200 ÷ 300°C. PWHT at 745°C for an hour.

## TECHNICAL INFORMATION

Gas: Mix Ar- O<sub>2</sub> (EN 14175)

Welding positions: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)	1.2	1.6	
Volts (V)	18 ÷ 34	19 ÷ 38	
Intensity (A)	100 ÷ 360	130 ÷ 450	

Diam.	15kg Spool
1.2mm	INMB61215
1.6mm	INMB61615

TALARC Pty Ltd  
10-16 Syme St  
Brunswick, Vic 3056  
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710  
W: [www.talarc.com](http://www.talarc.com) E: [sales@talarc.com](mailto:sales@talarc.com)