

TALARC B6 TIG

CLASSIFICATION

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

ALLOY TYPE

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

APPLICATIONS

Low alloy copper-coated tig rod 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.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.07	0.50	0.40	0.010	0.010	0.10	-	5.80	0.55

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	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
Argon	after PWHT	500	620	25	200	-	-	-	-

WELDING GUIDELINES

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

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding positions: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter (mm)	1.6	2.4
Length (mm)	1000	
Carton	5 Kg	
Current	DC - Straight (-) polarity	

Diam.	5kg Tube
1.6mm	INTB616
2.4mm	INTB624

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