

Gas Tungsten Arc Welding

**TG-S5CM**
**FAMILJARC**
**TIG welding rod and wire for 5%Cr-0.5%Mo heat resistant steel**
**Classification:** ASME / AWS A5.28 ER80S-B6

JIS Z3316 YGT5CM: TG-S5CM

JIS Z3316 YGT5CML: TG-S5CML

**Features :** •Suitable for 5%Cr-0.5%Mo steel

•Applied for :-

Plates : ASTM A387 Gr.5, P5, P5b or equivalent

Pipe / Tube : ASTM A335

**Shielding Gas:** Ar

**Polarity:** DC-EN

**Chemical composition of rod and wire (%) as per AWS**

	C	Si	Mn	P	S	NI	Cr	Mo	Cu
Example	0.09	0.41	0.49	0.006	0.009	0.04	5.44	0.55	0.12
Guaranty	≤0.10	≤0.50	0.40~ 0.70	≤0.025	≤0.025	≤0.60	4.50~ 6.00	0.45~ 0.65	≤0.35

**Mechanical properties of all-weld metal as per AWS**

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	480	600	26	0°C: 280	750x1
Guaranty	≥470	≥550	≥17	-	745±15x1

**Packages**

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g) (TG-S5CM)	Weight per piece (g) (TG-S5CML)
1.2	tube	5	1,000	9	-
1.6	tube	5	1,000	16	16
2.4	tube	5	1,000	35	35
3.2	tube	5	1,000	63	63