

## IABCO A32 TIG

### TIG/GTAW wire for low alloy steel

Product name	IABCO A32 TIG
Classification EN ISO	21952-A: W CrMo1Si
Material No.	1.7339
Classification AWS	A5.28: ER80S-G
Approvals	TÜV 12692.00, CE.
Applications	TIG/GTAW rod for high temperature creep resistant 1.25%Cr-0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries. The wire has low levels of tramp elements (eg. Sn, As, Sb & P) providing a low Bruscato (X) Factor for temper embrittlement resistant applications.
Base materials	For matching 1.25%Cr-0.5%Mo creep resisting ferritic steels. A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12 13CrMo 4-4, 13CrMo 4-5, 16CrMo 4-4, GS-17CrMo 5-5.
Typical analysis of wire, weight %	C: 0.10 Si: 0.60 Mn: 1.00 Cr: 1.20 Mo: 0.52
Typical heat treatment <sup>(1)</sup>	Preheat temperature: 200°C. Interpass temperature: 300°C. PWHT: 620-690°C.
Mechanical properties of weld deposit <sup>(2)</sup>	0.2% proof stress Rp0.2%: ≥479MPa. Tensile strength Rm: ≥550MPa. Elongation 4d/5d: ≥22%.
Other products	SAW: EB2. MIG/GMAW: A32, ER80S-B2. TIG/GTAW: ER80S-B2.

- Notes** (1) Application codes and project specifications should always be referred to for specific requirements.  
(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.