

Gas Tungsten Arc Welding

TG-SM
FAMILIARC
TIG welding rod and wire for Mo heat resistant steel
Classification: ASME / AWS A5.28 ER80S-G

JIS Z3316 YGT M

Features : •Suitable for 0.5% Mo steel

•Applied for ASTM A335 Grade P1, A209 and A250 Grade T1

Shielding Gas: Ar

Polarity: DC-EN

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

	C	Si	Mn	P	S	Ni	Mo	Cu
Example	0.08	0.54	1.04	0.004	0.007	0.02	0.53	0.12
Guaranty	0.05~ 0.12	≤0.80	≤1.50	≤0.025	≤0.025	≤0.20	0.40~ 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	500	580	32	0°C: 280	620x1
Guaranty	≥470	≥550	≥19	-	AW

Approvals

 AB
 MG

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g)	
				(TG-S1CM)	(TG-S1CML)
0.8	spool	10	-	○	-
1.0	spool	10	-	○	-
1.2	tube	5	1,000	9	-
	spool	10	-	○	○
1.6	spool	20	-	○	-
	tube	5	1,000	16	16
	spool	10	-	○	-
2.0	spool	20	-	○	-
	tube	5	1,000	25	25
2.4	tube	5	1,000	35	35
3.2	tube	5	1,000	63	63