

## MG 211

Gas Metal Arc (MAG) Welding Wire - Creep Resisting Steels

### Standards

AWS/ASME SFA - 5.28	ER80S-G
EN ISO 21952 - A	G CrMo1Si
TS EN ISO 21952 - A	G CrMo1Si
DIN M. No.	1.7339

### Properties and Applications

Low-alloy wire electrode for GMA (MIG/MAG) welding of Cr-Mo alloyed creep resistant boiler and pipe steels subjected to operating temperatures up to 570°C. Also suitable for joining C-Mn steels to be postweld heat treated. Observe directions as to pre and post weld heat treatment of base material. CO<sub>2</sub> or mixed shielding gases can be used depending on the thickness of the base metal. A thin and homogeneous copper coating increases electrical conductivity and protects the wire from rusting.

### Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.09	0.60	1.00	1.20	0.50

### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M21	630	750	18	20°C → 80
Isil İşlem Sonrası (685°C 1 Saat)	M21	500	600	28	20°C → 120

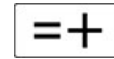
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (%82 Ar + %18 CO<sub>2</sub>).

### Application Information

#### Welding Positions



#### Polarity:



Protection Gas:  
M20 M21 C1

#### Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20
1.60

### Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22002BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002DMAM2	1.00	15 kg	15.20	1	15.20	Wire Basket Spool (K300)
22002EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

### Storage & Re-Drying Information

Shouldn't be exposed to high static load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.