

**SGQ  
SIAT S.p.A.**

## 1. DESCRIPTION

Gas shielded welding wire conforming to standard ISO 21952-A G Z and AWS A5.28 ER80S-B2 suitable for high temperature creep resistant 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 (Sn,As,Sb and P) providing a low Bruscato Factor ( $X < 10\text{ppm}$ ) for temper embrittlement resistant applications.

## 2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V
<b>PITTARC GCr1Mo</b>	Min	0.07	0.40	0.40	-	-	1.20	-	0.40	-	-	-
	Max	0.12	0.70	0.70	0.025	0.025	1.50	0.20	0.65	0.35	0,02	0.03
<b>ISO 21952-A- G-Z</b>	Min	0.07	0.40	0.40	-	-	1.20	-	0.40	-	-	-
	Max	0.12	0.70	0.70	0.025	0.025	1.50	0.20	0.65	0.35	-	-
<b>AWS A5.28 ER80S-B2</b>	Min	0.07	0.40	0.40	-	-	1.20	-	0.40	-	-	-
	Max	0.12	0.70	0.70	0.025	0.025	1.50	0.20	0.65	0.35	-	-

Note: The standard ISO AWS A5.28 require a total residual of other elements lower than 0,50%.

## 3. WIRE DIMENSIONS

Standard diameter [mm]: 0.8; 1.0; 1.2; 1.4; 1.6  
Permissible deviations: ISO 544

## 4. CAST AND HELIX (STANDARD PACKAGING)

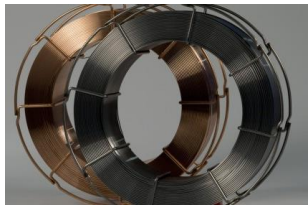
Cast [mm]: 800 ÷ 1000  
Helix [mm]: maximum 10

## 5. STANDARD PACKAGING



Wire basket rim RG (ISO 544 B300) of 18 kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 72 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (94x125x80 cm, 1296kg net weight). Available cardboard drums of about 250kg net weight, each one stacked onto a pallet 105x105x90 cm of about 1000kg total weight, secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 700 kg.

## 6. STANDARD IDENTIFICATION

A label is attached to the inside of each spool containing nominal diameter, trade name, heat number, operator code. A label is attached to every box containing manufacturer, trade name, nominal diameter, heat number, spool type, references to the standards, CE mark and approvals.



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 <b>PITTARC</b>	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
 0036 06 ref. DoP PITTARC GCr1Mo-2020-10 EN 13479:2017 Use in metallic structures or in composite metal and concrete structures	<b>PITTARC GCr1Mo</b>		
	Welding wire for carbon steels and fine-grained steels ISO 21952-A-G-Z and AWS A5.28 ER80S-B2		
	Weight kg XX	Heat N° XXXXX/XX	Spool type X XXX

## 8. STANDARD CERTIFICATION

Documents according to EN 10204.

## 9. APPROVALS

None.

