

# CARBO LS - CrMo 1

<b>International standards</b>	Material No.	1.7339
	EN 12070	GCrMo1Si WCrMo1Si
	AWS/ASME-A 5.28	ER 80 S-G

**Approvals** --- ---

**Application notes** Low alloyed laser welding wire for the manufacture of vessels, containers and pipelines for working temperatures up to 550°C. The alloy is suitable for heat treatable quenched and subsequently tempered steel as well as for tubes resistant to caustic embrittlements .

**Operating temperature** 20° C up to + 550° C

**Base materials**

1.7218 25CrMo4	1.7335 13CrMo4-5
1.7262 15CrMo5	1.7218 GS25CrMo4
1.7321 20MoCr4	1.7354 G22CrMo5-4

<b>Mechanical properties of all-weld-metal with Gas: M 21</b> (typical values)	<b>Tensile strength</b> R <sub>m</sub> N/mm <sup>2</sup>	<b>Yielding strength</b> R <sub>p0,2</sub> N/mm <sup>2</sup>	<b>Elongation</b> A <sub>5</sub> %	<b>Impact strength</b> ISO – V J at 20° C
	>500	>450	>20	>90

<b>Weld metal analysis</b> (typical, wt %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>
	0,08-0,14	0,50-0,80	0,80-1,20	0,90-1,30	0,40-0,65

**Gas types EN 439** I1 Argon

**coils, weight** Diameter in mm: 0,20 up to 0,60  
You can order the laser wire as coils, spools or straightened bars. The standard lengths of the straightened rods are 500 mm and 1000 mm.