

TECHNICAL DATA

Standards

DIN Material Nr. 1.7339

EN ISO 21952-A :	G CrMo1Si
AWS A5.28 :	ER80S-B2 mod.

General Properties / Field of Applications

DSI M Connect 8 is a Laser Welding Wire made of low-alloy chromium-molybdenum steel for welding 13CrMo4-5 and similar high-temperature steels for operating temperatures up to 570°C. The weld metal is heat treatable, has good strength and toughness values and is also resistant to alkali cracking and nitriding.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	510
Tensile strength R_m	[MPa] / [N/mm ²]	620
Maximum operating temp.	[°C]	570
Elongation A ($L_0 = 5d_0$)	[%]	24

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo
0.1	0.7	1.0	1.1	0.5

Compatible Materials (Selection)

1.7335 13CrMo4-5 / 1.7262 15CrMo5 / 1.7728 16CrMoV4 / 1.7225 42CrMo4
ASTM A 182 Gr. F12 / A 217 Gr. WC6 / A355 Gr. P11, P12 / A426 Gr. CP12

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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