

CLASSIFICATION

AWS A5.28: ER90S-B3
TS EN ISO 21952-A : W CrMo2Si*
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(*) Nearest classification

GENERAL DESCRIPTION

It is a low alloyed TIG rod, used for the welding high temperature strength Cr-Mo (2.25 % Cr, 1.0 % Mo) steels (boiler and pressure vessels) in operating temperatures up to 600°C. It gives a weld metal that is resistant to corrosion and sulphide materials.

Industry: Oil industry, thermal plants, chemical and petro-chemical industry

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Ni	Cr	Mo	Cu
0.08	0.50	0.60	<0.20	2.40	1.00	< 0.30

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 540 N/mm²
Tensile Strength : 640 N/mm²
Elongation (L=5d) : 22 %
Impact (ISO-V) : 150 J (+20°C)
90 J (-10°C)

SHIELDING GASES (ISO 14175 / EN 439)

TIG : I1 - Ar (100%)

Current Type and Polarity : DC (-)

MATERIALS TO BE WELDED

	DIN	EN	Wr. Nr
Creep Resistant Steels	-	10CrMo9-10	1.7380
	10 CrSiMoV 7	-	1.8075
	10 CrV 63	-	-
	12 CrSiMo 8	-	-
Cast Steels	GS-25 CrMo 4	G25CrMo4	1.7218
	GS-17 CrMo 5 5	G17CrMo5-5	1.7357
	GS-18 CrMo 9 10	G17CrMo9-10	1.7379

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Tube Weight
TIG ROD	-	-	-	X	X	X	-	5 kg

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.

Fumes : Consult information on Welding Safety Sheet, available upon request.

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