

SG CrMo2 Tig

CATEGORY	GMAW-GTAW Solid wires
TYPE	Copper coated Tig welding wire for welding creep and hydrogen -resistant steels.
APPLICATIONS	High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.
PROPERTIES	Extreme easy to weld with excellent welding properties. High world wide excepted quality with ultra clean weld deposit. Suitable for creep resistant service for working temperatures up to 600° Celsius.

CLASSIFICATION	AWS	A 5.28: ER 90 S-G A 5.28: ER 90S-B3 (mod)
	EN ISO	21952-A: WCrMo2Si
	DIN: W.Nr.	1.7384
	DIN	8575: SG CrMo2

SUITABLE FOR	Heat resistant steels: 10CrMo9 10 (1.7380), A335 Grade P 22, 10CrSiMoV7 (1.8075), G17CrMo 9 10 (1.7379)
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APPROVALS	CE approved
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WELDING POSITIONS:



WELD METAL ANALYSIS (TYPICAL) %

C	Mn	Si	Cr	Cu	Mo
0.07	1.00	0.65	2.55	< 0.30	1.00

MECHANICAL PROPERTIES (AFTER HEAT TREATMENT)

Heat treatment PWHT	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				20°C	40°C
720°C/2hr	> 450	> 550	> 23	> 80	

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing (kg)	
	Current (A) (DC-)		single	master
1.6 x 1000	50-80		5	25
2.0 x 1000	70-110		5	25
2.4 x 1000	110-180		5	25
3.2 x 1000	150-250		5	25

REDRYING TEMPERATURE	not required
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GAS ACC EN ISO 14175:	I1
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