

SG CrMo2

CATEGORY	GMAW-GTAW Solid wires
TYPE	Copper coated 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 controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas. Suitable for creep resistant service for working temperatures up to 600 ^o Celsius.

CLASSIFICATION	AWS	A 5.28: ER 90 S-G A 5.28: ER 90S-B3 (mod)
	EN ISO	21952-A: G CrMo2Si
	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)

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

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

MECHANICAL PROPERTIES (AFTER HEAT TREATMENT)

Shielding gas PWHT	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	
				20°C	40°C
720°C/2hr	> 420	> 520	> 23	> 80	

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.8	15-24	60-200	KD-300 / Drum	15 / 250	1080 / 1000
1.0	16-32	80-300	KD-300 / Drum	15 / 250	1080 / 1000
1.2	18-35	120-380	KD-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21