


CATEGORY	GTAW Solid wires																															
TYPE	Tig welding wire for creep resistant A387 P21 and P22 grades.																															
APPLICATIONS	TIG/GTAW filler metal for high temperature creep resistant 2.25%Cr1%Mo ferritic steel. These steels are used for creep resisting applications up to ~600°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.																															
PROPERTIES	The filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor.(X<10 ppm)for temper embrittlement resistant applications.																															
CLASSIFICATION	AWS	A 5.28: ER 90S-B3																														
	EN ISO	21952-B: W 2C1M																														
	F-nr	6																														
	FM	3																														
SUITABLE FOR	For matching 2.5%Cr1%Mo creep resisting ferritic steels EN: 10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9-10 ASTM: A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22																															
APPROVALS	CE																															
WELDING POSITIONS:																																
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>0.5</td> <td>0.55</td> <td>2.5</td> <td>1.1</td> </tr> </tbody> </table>			C	Si	Mn	Cr	Mo	0.09	0.5	0.55	2.5	1.1																			
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GAS ACCORDING EN 14175	I1																															