

## TIG wire and rod for 2.25%Cr-1%Mo steel

<b>Features:</b>	• Applied for ASTM A387 Gr.22 and equivalents
<b>Classification:</b>	AWS A5.28 ER90S-G
<b>Shielding Gas:</b>	Ar
<b>Identification color:</b>	1st Brown
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool				Tube		
	kg				kg	Length mm	g/piece
0.8	1	5	10	-	-	-	-
1.0	-	-	10	-	-	-	-
1.2	-	-	10	20	5	1,000	9
1.6	-	-	10	-	5	1,000	16
2.0	-	-	-	-	5	1,000	25
2.4	-	-	-	-	5	1,000	35
3.2	-	-	-	-	5	1,000	63
<b>Volume mm</b>	280W, 110H, 280L/10pcs	240W, 110H, 230L	280W, 110H, 270L		40W, 35H, 1015L		

## Composition (wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.11	0.05~0.15
<b>Si</b>	0.36	0.60
<b>Mn</b>	0.70	0.50~1.20
<b>P</b>	0.005	0.025
<b>S</b>	0.008	0.025
<b>Ni</b>	0.04	0.20
<b>Cr</b>	2.29	2.10~2.50
<b>Mo</b>	1.07	0.90~1.20
<b>Cu</b>	0.15	0.35

Note: <sup>a</sup>Single values are maximum.

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	610	538min.
<b>TS (MPa)</b>	720	621min.
<b>El on 4d (%)</b>	28	17min.
<b>IV 0°C (J)</b>	250	-
<b>PWHT (°C×h)</b>	690×1	690±15×1

## Approvals

<b>ABS</b>	MG
<b>LR</b>	MG
<b>DNV</b>	MG
<b>BV</b>	UP (ER90S-G)
<b>NK</b>	MG
<b>KR</b>	MG (ER90S-G)