

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

Features:	• Applied for ASTM A387 Gr.22 and equivalents
Classification:	AWS A5.28 ER90S-B3
Shielding Gas:	Ar
Identification color:	1st Brown
Polarity:	DCEN

Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.0	10	-	-	-
1.2	10	-	-	-
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	35
3.2	-	5	1,000	63
Volume mm	240W, 110H, 230L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.09	0.07~0.12
Si	0.64	0.40~0.70
Mn	0.60	0.40~0.70
P	0.004	0.025
S	0.006	0.025
Cr	2.39	2.30~2.70
Mo	1.08	0.90~1.20
Ni	0.06	0.20
Cu	0.15	0.35

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	596	538min.
TS (MPa)	725	621min.
EI on 4d (%)	27	17min.
IV -20°C (J)	237	-
PWHT (°C×h)	690x1	690±15x1