

S2 CrMo2

CATEGORY SAW Arc Submerged

TYPE Submerged Arc wire for welding temperature resistant boiler steels and base metals.

APPLICATIONS 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 Submerged arc welding wire for high temperature creep resistant 2,45%Cr 1,0%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire 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. Recommended flux: FL 155

CLASSIFICATION

AWS	A 5.23: EG
EN ISO	24598-A: SZCrMo2Mn
DIN	8575: S2 CrMo2

SUITABLE FOR ASTM: A182 grade F22, A199/A200 grades T21/T22, A213 grade T22, A217 grade WC9, A234 grade WP22, A335 grade P22, A387 grades 21/22 10CrMo 9-10, 10CrSiMoV 7, G-17CrMo 9-10

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo
0.10	0.95	0.25	2,45	1,0

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	40°C	60°C	
AW	> 470	>550	>20	> 47			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spools / drums	kg / pallet
1.6	27-30	150-300	K-415 / Drum	25-27 / 350	
2.0	28-34	180-320	K-415 / Drum	25-27 / 350	
2.4	28-38	250-500	K-415 / Drum	25-27 / 350	
3.0	28-40	400-800	K-415 / Drum	25-27 / 350	
4.0	28-40	500-900	K-415 / Drum	25-27 / 350	

REDRYING TEMPERATURE not required