

SG CrMo2 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated Tig 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 ultra clean weld deposit. Suitable for creep resistant service for working temperatures up to 600° Celsius.

CLASSIFICATION

AWS	A 5.28: ER 90 S-G A 5.28: ER 90S-B3 (mod)
EN ISO	21952-A: WCrMo2Si
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 (TYPICAL) %

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

MECHANICAL PROPERTIES (AFTER HEAT TREATMENT)

Heat treatment PWHT	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				20°C	40°C
720°C/2hr	> 450	> 550	> 23	> 80	

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters Current (A) (DC-)	Packing (kg)	
		single	master
1.6 x 1000	50-80	5	25
2,0 x 1000	70-110	5	25
2,4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

REDRYING TEMPERATURE not required

GAS ACC EN ISO 14175: I1