TIGWELD 2CrMo

CLASSIFICATION:
N ISO 21952-A: W CrMo2Si
DIN 8575: SG CrMo2
AWS A-5.28: ER 90S-G (ER 90S-B3 mod.)

APPROVALS:
UDT
TUV

DESCRIPTION:
- Welding rod with the addition of Cr and Mo for TIG welding.
- For welding creep resistant steels working under pressure.
- Weld working temperature up to 600°C.
- Bruscato's factor of X<10ppm ensures high resistance to temper brittleness.

APPLICATION:
Steam boilers, pipelines, fittings. Repair of thermoenergetic devices

BASE MATERIAL:

	EN	ASTM
Boiler plates	10CrMo910	A182 F22
	10CrMo 9-10	A199/A200 grades T21/T22
	G-17CrMo 9-10	A213 T22
		A217 WC9
		A234 WP22
		A335 P22
		A387 grades 21/22

For 2.5%Cr,1%Mo ferritic creep resistant steels

TYPICAL CHEMICAL COMPOSITION (%):
C 0,08 Si 0,60 Mn 0,90 Cr 2,45 Mo 1,00

TYPICAL MECHANICAL PROPERTIES:
Re: >400 N/mm2
Rm: >520 N/mm2
A5: >18%
Kv: >47J (-40°C)

Annealing: 720°C / 30 min, furnace cooling to 300°C, then in air.
X Factor: max 10 ppm

Shielding gases acc. to EN ISO 14175:
I1: Ar

Preheating temperature 200°C.
Interpass temperature max 300°C.

Welding parameters	Packing	
ϕ	Length [mm]	Weight of packet [kg]
1,6	1000	5,0/25,0
2,0	1000	5,0/25,0
2,4	1000	5,0/25,0
3,0	1000	5,0/25,0

RELATED PRODUCTS: MIGWELD 2CrMo, BASOWELD 2CrMo