MIGWELD 2CrMo

MIG/MAG Wires [GMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 21952-A : G CrMo2Si DIN 8575 : SG CrMo2 AWS A-5.28 : ER 90S-G	UDT, TUV	Power generation industry Hardfacing and repairing Constructions & Engineering Petrochemical and chemical industry

- Solid welding wire with the addition of Cr and Mo for MIG welding.
- For welding heat-resistant and creep-resistant steels from the 10CrMo9-10 group.
- For welding creep resistant steels working under pressure.
- Weld working temperature up to 600°C.
- Low Bruscato factor: X < 10ppm.
- Recommended for welding hardened and tempered steels together, as well as cementation and nitriding steels.

Application

Power steels, working temperature up to 600°C.

High-strength, low-alloy steels.

Pipelines, power boilers.

Base material

DIN/W.Nr	DIN	ASTM/UNS	PN
1.7380	10CrMo9-10	A182 F22, A182 T22	10H2M
1.7337	16CrMo4-4	A182 F12	
1.7262	15CrMo5		18HGM
1.7258	24CrMo5		25HM, 20HM
1.7350	22CrMo4-4		
1.7357	GS-17CrMo5-5	A217 WC6	
1.7015	15Cr3	A1031 Gr.5015	
1.7131	16MnCr5	A1031 Gr.5115	
1.7147	20MnCr5	A1031 Gr.4820	
1.8075	10CrSiV7		
1.7707	30CrMoV9	A1031 Gr.4340	
1.7379	GS-18CrMo9-10		
1.7383	11CrMo9-10		
1.7375	12CrMo9-10		
1.7385	6CrMo9-10		

Typical chemical composition %

C	Si	Mn	Cr	Mo
0,08	0,60	0,90	2,45	1,00

Typical mechanical properties

Yield strength Re [N/mm2]	>400
Tensile strength Rm [N/mm2]	>520
Elongation A5 [%]	>20

Impact energy Kv [J]	>80J (20°C) /
Heat treatment	Annealing: 720°C/30 min, furnace cooling to 300°C, then in air
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	80-95	17-19 short arc	15,0
1,0	240-270	24-27 spray arc	15,0
1,2	110-130	18-20 short arc	15,0
1,2	270-320	27-32 spray arc	15,0

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