TIGWELD 2CrMo

TIG Rods [GTAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 21952-A : W CrMo2Si DIN 8575 : SG CrMo2 AWS A-5.28 : ER 90S-G (ER 90S-B3 mod.)	UDT, TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- 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
Boiler plates	10CrMo910
ASTM	A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22,A387 grades 21/22
For 2.5%Cr,1%Mo ferritic creep resistant steels	
	10CrMo 9-10, G-17CrMo 9-10

Typical chemical composition %

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

Typical mechanical properties

Yield strength Re [N/mm2]	>400
Tensile strength Rm [N/mm2]	>520
Elongation A5 [%]	>18
Impact energy Kv [J]	>47J (-40°C) /
Heat treatment	Annealing: 720°C / 30 min, furnace cooling to 300°C, then in air
Additional description	X Factor: max 10 ppm
Shielding gases acc. to EN ISO 14175	I1 - Ar /
Remarks	Preheating temperature 200°C. Interpass temperature max 300°C.

Welding parameters and packing

ø	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

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