



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 13.17

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Per-Erik Andersson	Reg no EN006150	Cancelling EN006080	Reg date 2013-07-05	Page 1 (2)
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REASON FOR ISSUE

Chemical composition updated.

GENERAL

A copper coated, low-alloyed, chromium-molybdenum (2,5% Cr, 1,1 % Mo), solid wire for GMAW of creep resistant steels like SA-387 Grade 22, A335 Grade P22 or similar materials. High purity wire with a guaranteed Bruscato factor X<15.

Shielding Gas: M13, M21 (EN ISO 14175)

CLASSIFICATIONS Wire Electrode

EN ISO 21952-B G 62A 2C1M
SFA/AWS A5.28 ER90S-B3

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
	80Ar/20CO2 (M21)		
C	0.1	0.07	0.12
Si	0.5	0.40	0.70
Mn	0.5	0.40	0.70
P	0.008		0.015
S	0.005		0.015
Cr	2,4	2.30	2.70
Ni			0.20
Mo	1.0	0.90	1.20
Cu	0.15		0.35
X			15
Others tot			0.50

Comments:
X = (10P+5Sb+4Sn+As)/100
(values in ppm)
TEP = T1 + 3 (T2-T1) < 10°C

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
	80Ar/20CO2 (M21)	
	AWS	
	Stress relieved 690°C 1h	
Rp0.2 (MPa)	540	590
Rm (MPa)	620	720
A4-A5 (%)	17	22
at -40°C (J)		>47



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U Max
	Min	Max			Min	Max	Min	Max	Min	
1.0	80	280	15		1	5,4	2,7	14,7	18	28
1.2	120	350	18		1,5	6,6	2,7	12,4	20	33

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)

OTHER DATA

Preheat and interpass temperature 200-350°C.

Usually welding is followed by a stress relieving heat treatment at 600-700°C.
