



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.17

| | | | | | | |
|---------------------------|------------------------------|-----------------------------------|--------------------|------------------------|------------------------|---------------|
| Prepared by Mats Linde | Qualified by Tero Tolonen | Approved by Per-Erik Andersson | Reg no EN006149 | Cancelling EN006011 | 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 $X < 15$.

Preheat and interpass temperature 200-350 °C.

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

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (2,5%Cr, 1 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 21952-A Z CrMo2Si
EN ISO 21952-B W 62 2C1M
SFA/AWS A5.28 ER90S-B3

APPROVALS

CE EN 13479

CHEMICAL COMPOSITION

| | All Weld Metal (%) | Wire/Strip (%) | |
|------------|--------------------|----------------|-------|
| | Nom | Min | Max |
| Ar (l1) | | | |
| C | 0.08 | 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)
 $TEP = T1 + 3 (T2-T1) < 10^{\circ}C$

MECHANICAL PROPERTIES OF WELD METAL

| Properties | All Weld Metal | |
|--------------|--------------------------|-----|
| | Min | Typ |
| | Stress relieved 690°C 1h | |
| Rp0.2 (MPa) | 540 | 620 |
| Rm (MPa) | 620 | 730 |
| A4-A5 (%) | 17 | 22 |
| at -40°C (J) | | >47 |



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OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 2.0 and 2.4 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.
