



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.22

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Per-Erik Andersson	Reg no EN006089	Cancelling EN005785	Reg date 2013-05-23	Page 1 (2)
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REASON FOR ISSUE

TM Revised.

GENERAL

A copper coated, low alloyed, chromium-molybdenum (2,5% Cr, 1,0% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed high strength steels with a minimum yield strength less than 400 Mpa. For service temperatures up to 600°C. Similar to AWS A5.28 ER80S-B2.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (2.5 % Cr - 1.0 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 21952-A W CrMo2Si
 EN ISO 21952-B W 62 2C1M3
 SFA/AWS A5.28 ER90S-G

APPROVALS

VdTÜV 11884

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.06	0.04	0.10
Si	0.6	0.50	0.80
Mn	1.0	0.80	1.20
P	0.015		0.020
S	0.015		0.020
Cr	2.5	2.30	2.70
Mo	1.0	0.90	1.20
Cu			0.35

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	AWS and EN I1 (Ar)		EN I1 (Ar)	
	Stress relieved+ 690°C 1h		Stress relieved 720°C 1h	
	Min	Typ	Min	Typ
Rp0.2 (MPa)	540	550	400	530
Rm (MPa)	620	655	500	640
A4-A5 (%)	15	24	18	24
A5 (%)			18	24
at 20°C (J)		190	47	165
	Comments: EN ISO 21952-B		Comments: EN ISO 21952-A	



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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.
