



## MIG/MAG Welding Wire for High Strength and Low Alloyed Steels

### Classification

EN ISO 21952-A : G CrMo2Si\*  
 AWS A5.28 : ER90S-B3

(\* ) Nearest classification

### General Description

It is a low alloyed GMA welding wire, used for the welding high temperature strength Cr-Mo (2.25 % Cr, 1.0 % Mo) steels (boiler and pressure vessels) in operating temperatures up to 600°C. It gives a weld metal that is resistant to corrosion and sulphide materials.

**Industry:** Oil industry, thermal plant, chemical and petro-chemical industry.

### Chemical Composition (w%), Typical, Wire

C	Si	Mn	Ni	Cr	Mo	Cu
0.08	0.50	0.60	< 0.20	2.40	1.00	< 0.30

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 540 N/mm<sup>2</sup>  
 Tensile Strength : 640 N/mm<sup>2</sup>  
 Elongation (L=5d) : 22 %  
 Impact (ISO-V) : 150 J (+20°C)  
                           90 J (-10°C)

### Shielding Gases (ISO 14175 / EN 439)

MIG : M21 - Ar + 5-25% CO<sub>2</sub>  
 C1 - CO<sub>2</sub> (100%)

Current Type and Polarity : DC (+)

### Materials to be Welded

	DIN	EN	Wr. Nr.
<b>Creep Resistant Steels</b>	–	10CrMo9-10	1.7380
	10 CrSiMoV 7	–	1.8075
	10 CrV 63	–	–
	12 CrSiMo 8	–	–
<b>Cast Steels</b>	GS-25 CrMo 4	G25CrMo4	1.7218
	GS-17 CrMo 5 5	G17CrMo5-5	1.7357
	GS-18 CrMo 9 10	G17CrMo9-10	1.7379

### Packing and Diameter Informations

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG/MAG Wire	-	X	X	-	-	-	-	15 kg