



TIG Rod for High Strength and Low Alloyed Steels

Classification

AWS A5.28 : ER90S-B3
 TS EN ISO 21952-A : W CrMo2Si*
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(*) Nearest classification

General Description

It is a low alloyed TIG rod, 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 plants, 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/mm²
 Tensile Strength : 640 N/mm²
 Elongation (L=5d) : 22 %
 Impact (ISO-V) : 150 J (+20°C)
 90 J (-10°C)

Shielding Gases (ISO 14175 / EN 439)

TIG : I1 - Ar (100%)
 Current Type and Polarity : DC (-)

Materials to be Welded

	DIN	EN	Wr. Nr.
Creep Resistant Steels	–	10CrMo9-10	1.7380
	10 CrSiMoV 7	–	1.8075
	10 CrV 63	–	–
	12 CrSiMo 8	–	–
Cast Steels	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	Tube Weight
TIG Rod	-	-	-	X	X	X	-	5 kg