

MIG (GMAW) wires for mild and low alloyed steel

ED-SG CrMo 2				
Classification DIN EN ISO			Classification AWS	
21952-A GCrMo2Si			A5.28 ER90S-G	
Approvals			Material No.	
TÜV 10966.00, CE, DB 42.045.20			1.7384	
Characteristics and application				
MIG/GMAW wire for high temperature creep resistant 2.25%Cr1%Mo ferritic steel. These steels are used for creep resisting applications up to ~600°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries. The wire has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications.				
Base materials				
For matching 2.5%Cr1%Mo creep resisting ferritic steels. 10CrMo 9-10, G-17CrMo 9-10 ASTM: A182 grade F22, A199/A200 grades T21/T22, A213 grade T22, A217 grade WC9, A234 grade WP22, A335 grade P22, A387 grades 21/22				
Typical analysis in %				
C	Si	Mn	Cr	Mo
0,08	0,60	0,92	2,45	1,00
Typical heat treatment				
Preheat temperature: 200°C Interpass temperature: max. 300°C PWHT: 690°C				
Mechanical properties of the pure weld metal				
Yield strength in Mpa	Tensile strength in Mpa	Elongation in %	Charpy-V-Value (ISO-V) in J	
≥ 400	≥ 520	4d/5d: ≥20	RT ≥ 80	