TIG welding rods
for mild and low alloyed steel

FLIESS SINCE 1915

WSG P24

Classification DIN EN ISO	Classification AWS
21952-A WZCrMo2VNb	A5.28 ER90S-G
Approvals	**Material No.**
TÜV 11949.00, CE	-

Characteristics and application

TIG/GTAW rod for T24 creep resistant steel. The T24 alloy is a modified 2.25%Cr1%Mo alloy with additions of Nb and V to improve high temperature creep performance. The alloy finds use for waterwalls in ultra-super-critical (USC) boilers in the power generating industry.

Base materials

For matching alloy 24, 2.5%Cr1%Mo modified, creep resisting ferritic steels.
X7CrMoVTiB 10-10
ASTM: A213 T24

Typical analysis in %

C	Si	Mn	Cr	Mo	V	Nb
0,10	0,25	0,90	2,30	1,00	0,30	0,02

Typical heat treatment

Preheat temperature: Dependent on application either none or 150-200°C
Interpass temperature: max. 300°C
PWHT: Dependent on application either AW or730°C - 760°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
≥ 600	≥ 700	4d/5d: ≥15	RT ≥ 47