CEWELD SG CrMo2 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper coated TIG welding wire for welding creep and hydrogen –resistant steels for welding P21 and P22 steels.(CrMo2, B3)

APPLICATIONS

CEWELD® SG CrMo2 Tig exhibits a bainitic microstructure in the tempered and tempered condition. It is used for processing high-temperature steels in High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.

PROPERTIES

CEWELD® SG CrMo2 Tig is an extremely easy-to-weld rod with excellent welding properties. It typically contains 2.25 % chromium and 1.0 % molybdenum.
Suitable for heat-resistant applications at working temperatures up to 600 °C.

CLASSIFICATION

AWS	A 5.28: ER 90S-G, A 5.28: ~ER 90S-B3
EN ISO	21952-A: W CrMo2Si
W.Nr.	1.7384
F-nr	6
FM	3

SUITABLE FOR

2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%
1.7015, 1.7131, 1.7147, 1.7276, 1.7281,1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7383, 1.7385, 1.7707, 1.8075
10CrMo9-10, 10CrMo11, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,

ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Mo	Cu
0.08	0.56	0.93	2.48	1.05	0.05

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
720°C±15°C 2h	550	630	19	100	55	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1

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SG CRMO2 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411457

SG CRMO2 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411471

SG CRMO2 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411495

SG CRMO2 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411518