

## Classifications

EN ISO 21952-A	EN ISO 21952-B	AWS A5.28	Mat. No.
W CrMo2Si	W 62 2C1M3	ER90S-G [ER90S-B3(mod.)]	1.7384

## Characteristics and typical fields of application

Low-alloyed welding rod / wire for the welding with argon. Suitable for manufacturing creep resistant steels in boiler, tank, pipeline and nuclear reactor construction.

## Base materials

1.7380 - 10CrMo9-10 - ASTM A335 Gr. P22  
1.7379 - G17CrMo9-10 - ASTM A217 Gr. WC9

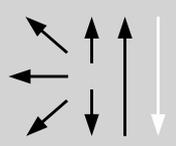
## Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Cr	Mo
wt-%	0.07	0.60	1.0	2.55	1.0

## Mechanical properties of all-weld metal

Heat-treatment	Shielding gas	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
		MPa	MPa	%	+20 °C
a	I1	470	590	20	80

## Operating data

	Polarity: DC (-)	Shielding gas: (EN ISO 14175) I 1-3	Marks: † W CrMo2 Si / ER 90S-G	ø mm	L mm
				2.0	1000
				2.5	1000
				3.0	1000

## Approvals

TÜV (00908), DB (42.132.41), CE