

Classifications

EN ISO 21952-A	AWS A5.28
WZ CrWV 2 1,5	ER90S-G

Characteristics and typical fields of application

Low-alloyed welding rod / wire for the welding with Argon. Suitable for creep resistant tubes and pipes in power stations.

Base materials

1.8201 – 7CrWVMoNb9-6 (EN 10216-2) – ASTM A213 Gr. T23
ASTM A335 Gr. P23; HCM2S – UNS K40712

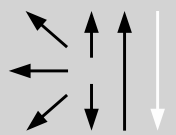
Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Cr	W	V	Nb	N
wt-%	0.07	0.3	0.5	2.2	1.7	0.22	0.05	0.01

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	600	700	15	47
740 °C / 2 h	500	620	17	100

Operating data

	Polarity:	Shielding gas:	Marks:	Ø (mm)	L mm
	DC (–)	(EN ISO 14175) I 1-3	✦ T / P23 / ER90S-G	2.0 2.4 3.2	1000 1000 1000

Approvals

TÜV (10271), CE