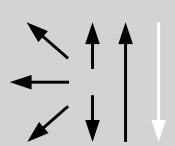


Classifications							
EN ISO 21952-A				AWS A5.28			
WZ CrMo2VTi/Nb				ER90S-G			
Characteristics and typical fields of application							
Low-alloyed welding rod / wire for the welding with Argon. Suitable for creep resistant tubes and pipes in power stations, especially 7CrMoVTiB10-10 (T24/P24)							
Base materials							
1.7378 – 7CrMoVTiB10-10 (T/P 24)							
Typical analysis of the TIG rods (wt.-%)							
	C	Si	Mn	Cr	Mo	V	Ti/Nb
wt-%	0.05	0.3	0.5	2.2	1.0	0.22	0.04
Mechanical properties of all-weld metal							
Heat-treatment	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
ungelüht	600		700		15		47
740 °C / 2 h	500		620		20		100
Creep rupture properties: Martensite, suitable for quenching and tempering							
Operating data							
	Polarity: DC ( – )	Shielding gas: (EN ISO 14175) I 1-3		Marks: ✦ T / P24 / ER90S-G	ø (mm) 2.0 2.4	L mm 1000 1000	
Approvals							
TÜV (10157), CE							