

Classifications

EN ISO 21952-A	AWS A5.28	AWS A5.28M
W ZCrWV2 1.5	ER90S-G	ER62S-G

Characteristics and typical fields of application

For manual or automatic GTAW-welding of creep resistant steels such as HCM2S (P23/T23 acc. to ASTM A 213 code case 2199), pipe or tube material.

Base materials

HCM2S, P/T23 ASTM A 213 code case 2199

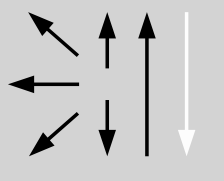
Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Cr	W	V	Nb
wt.-%	0.07	0.35	0.5	2.2	1.7	0.22	0.04

Mechanical properties of all-weld metal

Condition	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
u	≥ 600	≥ 700	≥ 15	≥ 47
a	≥ 500	≥ 600	≥ 17	≥ 47
u	untreated, as welded – shielding gas Argon			
a	annealed 740 °C/2 h			

Operating data

	Polarity: DC (–)	Shielding gas: 100 % Argon	Rod marking: front: †T/P23 back: ER90S-G	ø (mm)
				1.6
				2.0
				2.4
				3.2

Approvals

TÜV (10554.), CE