

## Classifications

EN ISO 21952-A	AWS A5.28	AWS A5.28M
W ZCrMoWVNb9 0.5 1.5	ER90S-B9 (mod.)	ER62S-B9 (mod.)

## Characteristics and typical fields of application

GTAW rod especially designed for the welding of a 9% Cr 1.5% W Mo-Nb-N / P92, NF616-steels. Approved in long-term condition up to +650 °C service temperature.

## Base materials

Similar alloyed creep resistant steels  
1.4901 X10CrWMoVNb9-2, NF 616  
ASTM A 213 Gr. T92 ; A 335 Gr. P92

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

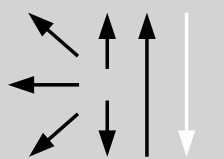
	C	Si	Mn	Cr	Ni	Mo	V	Nb	W	N
wt.-%	0.1	0.3	0.5	8.6	0.5	0.4	0.2	0.05	1.5	0.05

## 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
a	<b>670</b> ( $\geq 530$ )	<b>750</b> ( $\geq 620$ )	<b>19</b> ( $\geq 17$ )	<b>77</b> ( $\geq 41$ )
a1	<b>650</b>	<b>770</b>	<b>20</b>	<b>70</b>
a1 (650°C test temp.)	<b>230</b> ( $\geq 125$ )	<b>340</b>	<b>21</b>	

a annealed 760 °C/2 h / furnace down to 300 °C / air – shielding gas Argon  
a1 annealed 760 °C/6 h / furnace down to 300 °C / air – shielding gas Argon

## Operating data

	<b>Polarity:</b> DC (–)	<b>Shielding gas:</b> 100 % Argon	<b>Rod marking:</b> front: † P 92	<b>ø (mm)</b>
				2.0
				2.4
				3.2

## Approvals

TÜV (9292.), CE