Union I CrMo 910

Solid wire, low-alloyed

Classifications

EN ISO 21952-A	EN ISO 21952-B	AWS A5.28	Mat. No.
G CrMo2Si	G 62 M21 2C1M3	ER90S-G [ER90S-B3(mod.)]	1.7384

Characteristics and typical fields of application

Medium alloy solid wire electrode for gas-shielded arc welding both with gas mixture and CO_2. Applications include the welding of creep resistant steels in boiler, tank, pipeline and reactor construction.

Base materials

1.7380 – 10CrMo9-10; 1.7383 – 11CrMo9-10; 1.7379 – G17CrMo9-10; 1.7382 – G19CrMo9-10
ASTM A 182 Gr. F22; A 213 Gr. T22; A 217 Gr. WC9; A 234 Gr. WP22; A 335 Gr. P22; A 336 Gr. F22; A 426 Gr. CP22

Typical analysis of solid wire (wt.-%)

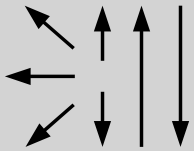
	C	Si	Mn	Cr	Mo
wt-%	0.09	0.60	1.05	1.10	0.50

Mechanical properties of all-weld metal

Heat-treatment	Shielding gas	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	M21*	460	570	20	65

*Also weldable with CO_2. in this case the mechanical properties will change.

Operating data



Polarity:	Shielding gas:	Ø mm	Spool:
DC (+)	(EN ISO 14175) M1 – M3 und C1	1.0 1.2	B300 B300

Approvals

TÜV (00907), DB (42.132.06), CE