



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 13.17

Signed by Mats Linde	Approved by Per Sundberg/Barbro Karlström	Reg no EN002285	Cancelling EN001043	Reg date 2004-07-02	Page 1 (2)
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## REASON FOR ISSUE

Mechanical properties modified.

## GENERAL

A copper coated, low-alloyed, chromium-molybdenum (2,5% Cr, 1,1 % Mo), solid wire for GMAW of creep resistant steels like SA-387 Grade 22, A335 Grade P22 or similar materials. High purity wire with a guaranteed Bruscato factor  $X < 15$ .

Preheat and interpass temperature 200-350 °C.

Usually welding is followed by a stress relieving heat treatment at 600-700 °C.

**Shielding Gas:** I1 (EN 439)

**Alloy Type:** Low alloyed steel (2,5%Cr, 1 % Mo)

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.28      ER90S-B3

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar (I1)			
C	0.08	0.07	0.12
Si	0.5	0.40	0.70
Mn	0.5	0.40	0.70
P	0.01		0.025
S	0.01		0.015
Cr	2.4	2.30	2.70
Mo	1.0	0.90	1.20
Cu	0.15		0.35
X			15
Others total			0.50
Comments:		Comments: X = (10P+5Sb+4Sn+As)/100 (values in ppm) TEP = T1 + 3 (T2-T1) < 10°C	

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Stress relieved 690°C 1h	
	Min	Typ
Rp0.2 (MPa)	540	620
Rm (MPa)	620	730
A4-A5 (%)	17	22
Charpy V at -40°C (J)		>47



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### OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 1.0, 1.6, 2.0, 2.4, 3.2 and 4.0 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.

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