



# CEWELD SG CrMo2 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                      |                      |                    |                         |       |          |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|----------------------|--------------------|-------------------------|-------|----------|
| TYPE                                              | Copper coated TIG welding wire for welding creep and hydrogen –resistant steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                      |                      |                    |                         |       |          |
| TOEPASSINGEN                                      | For High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                      |                      |                    |                         |       |          |
| EIGENSCHAPPEN                                     | Extreme easy to weld with excellent welding properties. High world wide excepted quality with ultra clean weld deposit. Suitable for creep resistant service for working temperatures up to 600° C.                                                                                                                                                                                                                                                                                                                                                          |                                      |                      |                    |                         |       |          |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | A 5.28: ER 90S-G, A 5.28: ~ER 90S-B3 |                      |                    |                         |       |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 21952-A: W CrMo2Si                   |                      |                    |                         |       |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 1.7384                               |                      |                    |                         |       |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 6                                    |                      |                    |                         |       |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 3                                    |                      |                    |                         |       |          |
| GESCHIKT VOOR                                     | <b>2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % &lt; Cr &lt; 3,5 % und 0,7%</b><br>1.7015, 1.7131, 1.7147, 1.7276, 1.7281,1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7383, 1.7385, 1.7707, 1.8075<br>10CrMo9-10, 10CrMo11, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,<br><br>ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820 |                                      |                      |                    |                         |       |          |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |       |          |
| LASPOSITIES                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |       |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Si                                   | Mn                   | Cr                 | Mo                      | Cu    |          |
|                                                   | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 0.56                                 | 0.93                 | 2.48               | 1.05                    | 0.05  |          |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | R <sub>P0,2</sub> (MPa)              | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                      |                      |                    | RT                      | -40°C |          |
|                                                   | 720°C±15°C 2h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 550                                  | 630                  | 19                 | 100                     | 55    | HRc      |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                      |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |       |          |



# CEWELD SG CrMo2 Tig

SG CRM02 TIG 1,6 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411457 |

SG CRM02 TIG 2,0 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411471 |

SG CRM02 TIG 2,4 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411495 |

SG CRM02 TIG 3,2 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663411518 |