



HILCO FER SGCrMo2

TIG rods – low alloyed steel – creep resisting

AWS A5.28: ER 90S-B3

EN ISO 21952-B : 2 C1M

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:
I1

Fer SGCrMo2 ER 90S-B3 is our solid wire for TIG welding low alloyed fine grain and creep resisting steels like 10CrMo9.10 up to a maximum operating temperature of 600°C. Typical applications include the construction of pressure vessels, boilers and pipes. To be used in combination with tungsten electrodes type WS2 Witstar®.

Base materials to be welded:

- Boiler steel 10CrMo9.10, A335 Grade P22, 10CrSiMoV7 (1.8075), G17CrMo9.10 (1.7379)
- Heat treatable steels up to 980 MPa tensile strength
- Case hardening and nitriding steels

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Mo
0,09	0,55	0,55	2,50	1,05

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 540	≥ 620	≥ 17	20°C ≥ 100 -40°C ≥ 47

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5