

Standards

TS EN ISO 21952-A	: G Z CrMo 2 Si
EN ISO 21952-A	: G Z CrMo 2 Si
TS EN ISO 21952-A	: W Z CrMo 2 Si
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AWS A5.28	: ER 90 S-B3

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.08	0.6	0.5	1.0	2.4

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 540	620 - 760	min. 47 J	min. 20	690°C/1hour-300°C air

Typical Base Material Grades

- 10 CrMo9-10, 10 CrSiMoV 7, 10 CrV 63, G-17 CrMo 9-10, A335 Gr. P22

Features and Applications

- Used for the welding of high heat resisting
- XCr-Mo alloyed steels which are used for the production of boilers tubes, pipes and nitrated steels
- Weld metal is resistant to temperatures up to +600°C
- Shielding gases: MAG; Ar+CO₂ and Ar+O₂ mix gases, TIG; pure Ar gas can be used

Welding Positions

Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010202185	3010202208	0.8	0.030"	15	D 200
3010202187	3010202210	1.0	0.040"	15	D 100
3010202189	3010202212	1.2	0.047"	15	ECO PACK
3010202190	3010202214	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1,14,1,4)		(1,5,15,18,50,250,400)	
	3010300367	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300368	2,00 x 1000	5/64 x 39"	5	
	3010300369	2,40 x 1000	3/32 x 39"	5	
	3010300370	3,20 x 1000	1/8 x 39"	5	
	3010300371	4,00 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO