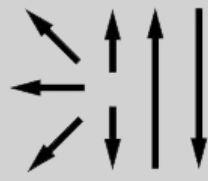


Standard classification									
AWS A5.28			EN ISO 21952-A				GB/T8110		
ER90S-G (ER90S-B3mod.)			G CrMo2Si				ER62-G		
Features and field of application									
Applicable for 2.25Cr-1Mo gas metal arc welding of low alloy heat resistant steel, suitable for boiler, pressure vessel, storage tank, and MIG welding of heat resistant pipes.									
Base material									
10CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22. SA217Gr. WC9, ...									
Chemical composition – typical values (Wt.%)									
C	Si	Mn	P	S	Cr	Mo	Cu		
0.08	0.60	0.90	≤0.010	≤0.006	2.50	1.00	≤0.30		
Mechanical properties of all weld deposit (AWS B4.0M)									
PWHT		R _{p0,2}		R _m		A ₄		K _v (J)	
		MPa		MPa		%		+20°C	
690°C/1h (M21)		570(≥540)		680(≥620)		25 (≥ 18)		160(≥47)	
Operating data									
		Polarity:			Size (mm)		Shielding gas:		
		DC +			0.8		ISO 14175		
					0.9		M21		
					1.0				
					1.2				
			1.6						
Approvals									
CE, TÜV									