TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP CrMo2Si — CREEP RESISTANT

CLASSIFICATIONS

EN ISO 21952-A	AWS A5.28
G CrMo2Si	ER90S-G

KEY FEATURES AND APPLICATIONS

- 2.25% Cr, and 1.0% Mo alloyed wire intended for welding similar composition steels.
- Typically used for high-strength, creep-resistant low-alloy steel welding applications.
- The presence of molybdenum helps resist hydrogen attack in chemical process applications.
- Ideal for service temperature up to 600°C max.
- Commonly used on equipment in the steam power generation industry, boiler and heat exchanger tubes, chemical and petrochemical processing equipment.

BASE MATERIALS

10CrMo9-10; 10CrSiMoV7; G17CrMo9-10 A355:P 22, GS 10CrSiMoV7, 12CrSiMo8, GS17CrMoV511

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Cr	Mo	Cu
MIN	0.04	0.50	0.80	-	-	2.3	0.90	-
MAX	0.12	0.80	1.20	0.020	0.020	3.0	1.20	0.35

Single values are maximum values according to EN ISO 21952

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
550	650	22	150	20ºC

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP15218	0.8	BS300	15	72
XP15221	1.0	BS300	15	72
XP15224	1.2	BS300	15	72

MADE IN EU