

XP ER 90S-G (A33)

CREEP RESISTANT



CLASSIFICATIONS

EN ISO 21952-A	AWS A5.28
W 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	20°C

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 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP15340	1.6	1000	5	PAP 20 Tube
XP15342	2.4	1000	5	PAP 20 Tube
XP15344	3.2	1000	5	PAP 20 Tube

