

CARBOFIL CrMo 2

MIG-MAG Wires C-Mn and low-alloy steels

Carbofil CrMo2 is a copper coated solid wire suitable for the welding of low alloyed 2,25% Cr steels or 10 Cr Mo 910-G5 or 10 Cr Mo 910 steels. Excellent weld deposit mechanical properties and impact toughness. Good x-ray quality.

Classification	
AWS	A5.28: ER 90S-G
EN	12070: G CrMo2 Si

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.09	1.20	0.70	≤ 0.020	≤ 0.020	2.50	-	1	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
PWHT 690°C x 1h	≥ 400	≥ 620	≥ 18	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

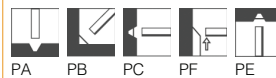
10CrMo9-10, 12CrMo9-10; A387 Gr.22, Cl 1 and 2, A 182 Gr.F 22, A 336 Gr.F22

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC +



Packaging data: K300 Kg. 16

Diameters	0,8	1,0	1,2	1,6		