

TIG Rods C-Mn steels and low-alloy steels

Carborod CrMo2 is a TIG rod suitable for welding low alloy 2,25% Cr steels, 10 Cr Mo 910-G5 and 10 Cr Mo 9-10 steels. Excellent mechanical properties. Good x-ray quality.

Classification	
AWS	A5.28: ER 90S-G
EN	12070: W 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	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) -29°C	Hardness
PWHT 690°C x 1h	≥ 400	≥ 620	≥ 18	≥ 70	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

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-					
					
PA	PB	PC	PF	PE	PF2

Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	1,6	2,0	2,4	3,2		

Further forms of delivery on request.