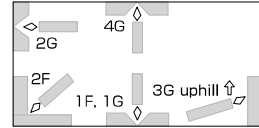


Solid wire for 2.25%Cr-1%Mo steel**Features:** - Applied for ASTM A387 Gr.22 and equivalents**Classification:** AWS A5.28 ER90S-G**Shielding gas:** Ar-2~5%O₂, Ar-5~20%CO₂**Polarity:** DCEP**Welding Positions:****Packaging data**

φ mm	Spool		Drum		
	kg	kg	kg	kg	kg
0.9	10kg	-	-	-	-
1.0	10kg	-	-	-	-
1.2	10kg	20kg	100kg	250kg	400kg
1.4	-	20kg	-	250kg	-
1.6	-	20kg	-	-	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530 φ, 820H		680 φ, 770H

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.07	0.12
Si	0.56	0.30~0.90
Mn	1.03	0.75~1.40
P	0.005	0.025
S	0.008	0.025
Cr	2.35	2.10~2.70
Mo	1.11	0.90~1.20
Cu	0.17	0.40

Note: ^aSingle values are maximum.**Welding parameters (A)**

φ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	240~300	130~190

All-weld mechanical properties

	Typical		Guaranty
	MPa	MPa	min.
0.2%YS (MPa)	580	430	538min.
TS (MPa)	680	570	621min.
EI on 4d (%)	23	30	17min.
IV 0°C (J)	190	140	-
PWHT (°C xh)	690x1	690x15	690±15x1
SG	Ar-2%O ₂	Ar-20%CO ₂	Ar-2%O ₂

Approvals

LR	MG
NK	MG