



TIG/MIG Filler Wire

2CrMo Steels

AWS A5.28: ER90S-G
BS 2901 Pt1: A33 (Obs.)
BS EN 12070 1999 CrMo-2Si

CMW-1920

DESCRIPTION & APPLICATION

TIG/MIG Filler Wire for the joining or overlay of 2.5%/1% CrMo creep resisting steels.

BASE MATERIALS

DIN 17155, 17254 10CrM)9.10-10CrSiMOV7
24 Cr Mo V55-12CrMo9.10, GS 12 Cr Mo 9.10
BS 1501. Gr622 -1504 Gr622, BS 359 Gr622/640, 1503 Gr660, 1504 Gr660
ASTM A387 GrD-A335 GrP22 -A213 GrT22,T36

MECHANICAL PROPERTIES

580	470	23	-
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HB

METAL WELD COMPOSITION %

C	Si	Mn	Cr	S	P	Mo	Fe
0.06	0.7	1.1	2.5	0.02	0.02	1.0	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

1.6, 2.4, 3.2mm (TIG)
0.8, 1.0, 1.2mm (MIG)

WELDING INSTRUCTIONS

Preheat as per the requirements of the base material.