OK Tigrod 13.17

A copper coated, low-alloyed, chromium-molybdenum (2,5% Cr, 1,1 % Mo), solid wire for GTAW of creep resistant steels like SA-387 Grade 22, A335 Grade P22 or similar materials. High purity wire with a guaranteed Bruscato factor, X-bar <15. Usually welding is followed by a stress relieving heat treatment at 600-700 °C.

Specifications	
Classifications	EN ISO 21952-A : Z CrMo2Si EN ISO 21952-B : W 62 2C1M SFA/AWS A5.28 : ER90S-B3
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Low alloyed steel (2,5%Cr, 1 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
PWHT 1 hour(s) 690 °C	570 MPa	690 MPa	27 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
AWS		
PWHT 1 hour(s) 690 °C	-40 °C	150 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**S**	**P**	**Cr**	**Mo**	**Cu**
0.08	0.5	0.5	0.005	0.008	2.4	1.0	0.15

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.08	0.5	0.5	0.05	2.4	1.0