



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 13.22

Signed by Mats Linde	Approved by M Bergenstråhle/Christos Skodras	Reg no EN004631	Cancelling EN003314	Reg date 2008-12-01	Page 1 (2)
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## REASON FOR ISSUE

EN 12070 replaced by EN ISO 21952

## GENERAL

A copper coated, low alloyed, chromium-molybdenum (2,5% Cr, 1,0% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed high strength steels with a minimum yield strength less than 400 Mpa.

For service temperatures up to 600°C

**Shielding Gas:** I1 (EN 439)

**Alloy Type:** Low alloyed steel (2.5 % Cr - 1.0 % Mo)

## CLASSIFICATIONS Wire Electrode

EN ISO 21952-A	W CrMo2Si
EN ISO 21952-B	W 62 2C1M3
SFA/AWS A5.28	ER90S-G

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.06	0.04	0.10
Si	0.6	0.50	0.80
Mn	1.0	0.80	1.20
P	0.015		0.020
S	0.015		0.020
Cr	2.5	2.30	2.70
Mo	1.0	0.90	1.20
Cu			0.35

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	EN Ar (I1)	EN Ar (I1)	AWS Ar (I1)	AWS Ar (I1)
	As welded	Stress relieved 750°C 0.5h	As welded	Stress relieved 640°C 2h
	Typ	Min Typ	Min Typ	Typ
Rp0.2 (MPa)	710	400		792 551
Rp1.0 (MPa)	740			836
Rm (MPa)	900	500	620	956 629
A4-A5 (%)	20	18		25 25
Charpy V at 20°C (J)	120	47	200	81
Charpy V at -20°C (J)				58 176
Charpy V at -30°C (J)				38 177
Charpy V at -40°C (J)				36 182



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### OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 2.0 and 2.4 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.

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