

CARBOFIL CrMo2 is a copper coated GCrMo2Si/ER90S-G type solid MAG welding wire supplied precision layer wound, depositing a 2¼Cr1Mo weld metal for the welding of creep resistant steels. Ar-CO2 mixed shielding gases preferred for improved mechanical properties.

CARBOFIL CrMo2 is used for welding of similar composition and ½Mo¼V and 1Cr1Mo steels. Used in the construction of steam generating plant operating at temperatures up to 600°C. Also suitable for the welding of 1¼Cr½Mo steels where improved resistance to hydrogen attack or corrosion by sulphur is required. Main applications include the welding of boilers, plates and tubes as well as oil refineries e.g. in crack plants produced from mainly 10CrMo9-10 (ASTM A335 Gr. P/T22).

CARBOFIL CrMo2 is used, where the operational guidelines are given by the EN norms.

Solid wire suitable for welding 2.25% Cr 1% Mo low-alloy steels. Excellent mechanical characteristics. Deposit insensitive to cracking. Good radiographic quality.

Classification		Approvals	Grade
EN ISO	21952-A: G CrMo2Si	TÜV	●
AWS	A5.28: ER 90S-G	CE	

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S	Cr	Mo
Wire	0.09	1.2	0.7	≤0.020	≤0.020	2.5	1.0
All weld metal (*)	0.07	0.9	0.5	≤0.020	≤0.020	2.4	1.0

(*) 82% Ar+18% CO2

All-weld metal Mechanical Properties


Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
690 °C x 1h	≥ 400	≥ 620	≥ 18	≥ 47

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M20, M21, M24, M26

Materials

10CrMo9-10, 10CrSiMoV7, 12CrMo9-10, G17CrMo9-10; ASTM A387 Gr.22, Cl 1 and 2, A 182 Gr.F 22, A 336 Gr.F22

Storage	Current condition and welding position
Keep dry and avoid condensation.	DC+
	

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.0	W000282963