# CARBOFIL CrMo2



# MIG/MAG solid wires-TIG rods C-Mn and low-alloy steels

CARBOFIL CrMo2 is a copper coated GCrMo2Si/ER90S-G type solid MAG welding wire supplied precision layer wound, depositing a 21/4Cr1Mo 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 gidelines 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				
EN ISO	21952-A: G CrMo2Si			
AWS	A5.28: ER 90S-G			

Approvals	Grade
TÜV	•
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## **Chemical analysis (Typical values in %)**

	C	Mn	Si	Р	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

<sup>(\*) 82%</sup> Ar+18% CO2

### **All-weld metal Mechanical Properties**

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

Gas test: 82% Ar+18% CO2

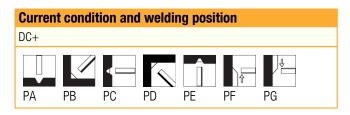
**Shielding Gas -** EN ISO 14175 : M20, M21, M24, M26

### **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**

Keep dry and avoid condensation.



## **Packaging data**

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

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