

# ALTIG CrMo2 E

## TIG Rods

C-Mn steels and low-alloy steels

SAF-FRO

ALTIG CrMo2 E is a copper coated WCrMo2Si/ER90S-G type solid TIG welding rod depositing a 2¼Cr 1Mo weld metal for the welding of creep resistant steels. Suitable for use with Ar shielding gas.

ALTIG CrMo2 E is used for welding of similar composition and ½Mo ¼V and 1%Cr 1Mo steels. Used in the construction of steam generating plant operating at temperatures <600°C. Also suitable for the welding of 1¼Cr 1Mo 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 in oil refineries e.g. in crack plants produced from mainly 10CrMo9-10 (ASTM A335 Gr. P/T22).

ALTIG CrMo2 E is specified, where the operational guidelines are given by EN norms.

Classification		CE
EN ISO	21952-A: W CrMo2 Si	
AWS	A5.28: ER 90S-G	

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.09	1.1	0.7	≤ 0.020	≤ 0.020	2.5	1

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-30 °C
690 °C x 1h	≥ 400	≥ 620	≥ 22	≥ 120	≥ 70


Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

### Materials

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

Storage
Keep dry and avoid condensation

Current condition and welding position
DC-

PA PB PC PD PE PF PG

### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.4	TUB	5	●