

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	-40 °C	150 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.08	0.5	0.5	0.05	2.4	1.0

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