

TG 201

TIG Welding Wire - Creep Resisting Steels

Standards	
AWS/ASME SFA - 5.28	ER70S-A1
AWS/ASME SFA - 5.28	ER80S-G
EN ISO 21952 - A	W MoSi
TS EN ISO 21952 - A	W MoSi
DIN M. No.	1.5424

Properties and Applications

Low alloyed GTA (TIG) welding rod for Mo-alloyed creep resisting steels, subjected to operating temperatures up to 530°C. Particularly used in root and cap passes of steam generators joints, boilers, pressure vessels and pipes, where high X-ray quality is required. Also suitable for welding carbon steel parts subsequently heat treated after welding. Observe directions of pre- and post-weld heat treatment of base metal.

Approvals & Certificates	
TUV	CE
Materials	
Width	DIN
P235G1TH - P255G1TH	St 35.8 - St 45.8
S255N - S420N	StE 255 - StE 420
P235GH, P265GH	H I, H II
P295GH	17Mn4
16Mo3	15 Mo 3
L360NB - L415NB	StE 360.7 - StE 415.7
L360MB - L415MB	StE 360.7 TM - StE 415.7 TM
	X52 - X60

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Mo
Welding Wire	0,10	0,80	1,00	0,50

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	540	620	26	20°C → 110	-20°C → 60
Isıl İşlem Sonrası (620°C 1 Saat)	I1	530	610	27	20°C → 150	

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
1.60x1000
2.00x1000
2.40x1000
3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22100GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
22100HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22100IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22100LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.