TG 222

TIG Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER90S-G
EN ISO 21952 - A	W CrMo2Si
TS EN ISO 21952 - A	W CrMo2Si
DIN M. No.	1.7384

Materials

Width	DIN
10CrMo9-10	10 CrMo 9 10

Properties and Applications

Low alloyed, GTA (TIG) welding rod for Cr-Mo alloyed creep resisting steels, subjected to operating temperatures up to 600°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.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.08	0.60	0.90	2.45	1.00

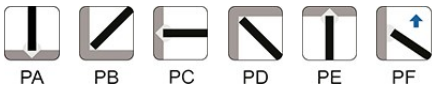
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	I1	560	650	22	20°C → 100
Isıl İşlem Sonrası (720°C 1 Saat)	I1	550	640	23	20°C → 110

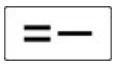
* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
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
22104HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22104IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22104LBKM2	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.