

## TG 222A

TIG Welding Wire - Creep Resisting Steels

### Standards

AWS/ASME SFA - 5.28	ER90S-B3
EN ISO 21952 - B	W 62 2C1M
TS EN ISO 21952 - B	W 62 2C1M

### Properties and Applications

Low alloyed, GTA (TIG) welding rod for Cr-Mo alloyed creep resisting steels, subjected to operating temperatures up to 600°C. Contains high level of deoxidizing (Mn and Si) elements to control porosity during welding. Particularly used in root and cap pass welding 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.

### Materials

Width	DIN
10CrMo9-10	10 CrMo 9 10

### Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.10	0,50	0,50	2.50	1.00

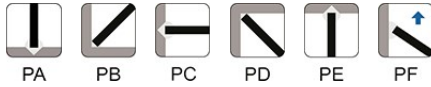
### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
Isil İşlem Sonrası (690°C 2 Saat)	I1	560	650	22	20°C → 110

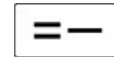
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

### Application Information

#### Welding Positions



#### Polarity:



#### Protection Gas:

I1

#### Welding Parameters & Efficiency

Diameter x Length (mm)
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
22105GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
22105HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22105IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22105LBKM2	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.