

TG 235

TIG Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER80S-B6
EN ISO 21952 - A	W CrMo5Si
TS EN ISO 21952 - A	W CrMo5Si
DIN M. No.	1.7373

Properties and Applications

Medium-alloyed GTA (TIG) welding rod for Cr-Mo alloyed creep resisting steels, subjected to operating temperatures up to 650°C. Suitable for welding 12 CrMo19-5, P5 / T5 steels in power generation and petrochemical industries. Due to its high steam and hot hydrogen corrosion resistance, particularly used in root and cap passes of in steam generators, boilers, piping in refineries, where high X-ray quality is required. Observe directions of pre- and post-weld heat treatment of base metal.

Materials

Width	DIN
X12CrMo5	12 CrMo 19 5
GX12CrMo5	GS-12 CrMo 19 5

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.10	0.40	0,50	6.00	0.55

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	580	660	23	20°C → 80
Islil İşlem Sonrası (740°C 2 Saat)	I1	570	650	24	20°C → 100

* 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)
2.00x1000
2.40x1000

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
22106HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22106IBKM2	2.40x1000	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.