TG 285

TIG Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER80S-B8
EN ISO 21952 - A	W CrMo9
TS EN ISO 21952 - A	W CrMo9

Materials

ASTM
A182-F9
A199-T9
A213-T9
A335-P9
A336-F9
A387-Grade 9

Properties and Applications

9Cr- 1Mo alloyed GTA (TIG) welding rod for creep resisting steels, subjected to operating temperatures up to 600°C. Suitable for welding P9 / T9 steels in power generation and petrochemical industries. Due to it's high steam and hot hydrogen corrosion resistance, particularly used in root and cap passes of in steam generators, boilers, pressure vessels and piping in refineries, where high X-ray quality is required. Observe directions of pre- and post-weld heat treatment of base metal. Stick Electrode : EM 285

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo
Welding Wire	0.08	0.40	0.60	9.00	0.20	1.00

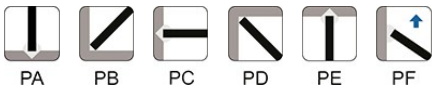
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
Isıl İşlem Sonrası (740°C 2 Saat)	I1	610	700	20	20°C → 110

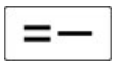
* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.00x1000
2.40x1000

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
22107HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22107IBKM2	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.