

Classifications

EN ISO 21952-B:2007	: W 62 2C1M	JIS Z 3317	: W 62-2C1M
AWS A5.28-05	: ER90S-B3	KS D 7140	: YGT2CM

Description

- For butt and fillet welding of power plant, heat exchanger and oil refineries such as 2.25%Cr-1%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- Preheat at 150°C to 300°C and post weld heat treatment at 680°C to 730°C is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Cr	Mo
0.09	0.47	0.66	0.010	0.014	2.31	1.00

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0°C	Remarks
AWS A5.28	min. 540	min. 620	min. 17	—	PWHT, Ar
EN ISO 21952-B	min. 540	min. 620	min. 15	—	PWHT
Example	550	670	26	180	PWHT, Ar

* PWHT : 690°Cx1Hr

Operating data

Dia.(mm)	2.4~3.2
Current (Amp.)	200 ~ 300

Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25ℓ/min)