

Низколегированные проволоки и прутки для дуговой сварки в среде защитного газа SG CrMo

Технические характеристики

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Standards

TS EN ISO 21952-A	: G Z CrMo 1 Si
EN ISO 21952-A	: G Z CrMo 1 Si
TS EN ISO 21952-A	: W Z CrMo1 Si
EN ISO 21952-A	: W Z CrMo1 Si
AWS A5.28	: ER 80 S-B2

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.10	0.6	0.5	0.5	1.2

Mechanical Properties

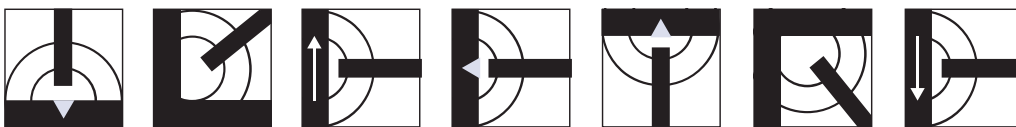
Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 470	550 - 670	min. 47 J	min. 19	620°C/1hour-300°C air

Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 42CrMo4, 16CrMoV4, 25CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, A 333Gr; P11

Features and Applications

- Used for the welding of high heat resisting. Cr-Mo alloyed steels which are used for the production of boilers tubes and pipes and nitrided steels
- Weld metal is resistant to temperatures up to +570°C
- Shielding gases: MAG; Ar+CO₂ and Ar+ O₂ mix gases, TIG; pure Ar gas can be used

Welding Positions**Current Type**

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010201750	3010201776	0.8	0.030"	15	D 200
3010201752	3010201778	1.0	0.040"	15	D 100
3010201754	3010201780	1.2	0.047"	15	ECO PACK
3010201755	3010201782	1.6	0.062"	15	BIG PACK
		(0,6,0.9, 1.14,1.4)		(1,5,15,18,50,250,400)	
	3010300326	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300327	2,00 x 1000	5/64 x 39"	5	
	3010300328	2,40 x 1000	3/32 x 39"	5	
	3010300329	3,20 x 1000	1/8 x 39"	5	
	3010300330	4,00 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO

Heat Resisting Arc Welding Wires & Rods

SG CrMo 1 Si

Standards

TS EN ISO 21952-A	: G CrMo 1 Si
EN ISO 21952-A	: G CrMo 1 Si
TS EN ISO 21952-A	: W CrMo 1 Si
EN ISO 21952-A	: W CrMo 1 Si
AWSA5.28	: ER 80 S-G

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.10	0.6	1.0	0.5	1.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 470	550 - 670	min. 47 J	min. 20	680°C/1hour-300°C air

Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 42CrMo4, 16CrMoV4, 25CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5

Features and Applications

- Used for the welding of high heat resisting. Cr-Mo alloyed steels which are used for the production of boilers tubes and pipes and nitrided steels
- Weld metal is resistant to temperatures up to +570°C
- Shielding gases: MAG; Ar+CO₂ and Ar+O₂ mix gases, TIG; pure Ar gas can be used

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010201969	3010201992	0.8	0.030"	15	D 200
3010201971	3010201994	1.0	0.040"	15	D 100
3010201973	3010201996	1.2	0.047"	15	ECO PACK
3010201974	3010201998	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1.14,1.4)		(1,5,15,18,50,250,400)	
	3010300360	1.6 x 1000	1/16 x 39"	5	Carton Box
	3010300361	2.0 x 1000	5/64 x 39"	5	
	3010300362	2.4 x 1000	3/32 x 39"	5	
	3010300363	3.2 x 1000	1/8 x 39"	5	
	3010300364	4.0 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO

Heat Resisting Arc Welding Wires & Rods

SG CrMo 2

Standards

TS EN ISO 21952-A	: G Z CrMo 2 Si
EN ISO 21952-A	: G Z CrMo 2 Si
TS EN ISO 21952-A	: W Z CrMo 2 Si
EN ISO 21952-A	: W Z CrMo 2 Si
AWS A5.28	: ER 90 S-B3

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.08	0.6	0.5	1.0	2.4

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 540	620 - 760	min. 47 J	min. 20	690°C/1hour-300°C air

Typical Base Material Grades

- 10 CrMo9-10, 10 CrSiMoV 7, 10 CrV 63, G-17 CrMo 9-10, A335 Gr. P22

Features and Applications

- Used for the welding of high heat resisting
- XCr-Mo alloyed steels which are used for the production of boilers tubes, pipes and nitrided steels
- Weld metal is resistant to temperatures up to +600°C
- Shielding gases: MAG; Ar+CO₂ and Ar+O₂ mix gases, TIG; pure Ar gas can be used

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010202185	3010202208	0.8	0.030"	15	D 200
3010202187	3010202210	1.0	0.040"	15	D 100
3010202189	3010202212	1.2	0.047"	15	ECO PACK
3010202190	3010202214	1.6	0.062"	15	BIG PACK
		(0,6,0,9,1.14,1.4)		(1,5,15,18,50,250,400)	
	3010300367	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300368	2,00 x 1000	5/64 x 39"	5	
	3010300369	2,40 x 1000	3/32 x 39"	5	
	3010300370	3,20 x 1000	1/8 x 39"	5	
	3010300371	4,00 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO

Heat Resisting Arc Welding Wires & Rods

SG CrMo 2 Si

Standards

TS EN ISO 21952-A	: G CrMo 2 Si
EN ISO 21952-A	: G CrMo 2 Si
TS EN ISO 21952-A	: W CrMo 2 Si
EN ISO 21952-A	: W CrMo 2 Si
AWS A5.28	: ER 90 S-G

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.08	0.6	1.0	1.0	2.4

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 540	620 - 760	min. 47 J	min. 20	720°C/1hour-300°C air

Typical Base Material Grades

- 10 CrMo9-10, 10 CrSiMoV 7, 10 CrV 63, G-17 CrMo 9-10, A 335 Gr. P22

Features and Applications

- Used for the welding of high heat resisting
- XCr-Mo alloyed steels which are used for the production of boilers tubes, pipes and nitrided steels
- Weld metal is resistant to temperatures up to +600°C
- Shielding gases: MAG; Ar+CO₂ and Ar+O₂ mix gases, TIG; pure Ar gas can be used

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010202401	3010202424	0.8	0.030"	15	D 200
3010202403	3010202426	1.0	0.040"	15	D 100
3010202405	3010202428	1.2	0.047"	15	ECO PACK
3010202406	3010202430	1.6	0.062"	15	BIG PACK
		(0,6,0.9, 1.14,1.4)		(1,5,15,18,50,250,400)	
	3010300400	1.6 x 1000	1/16 x 39"	5	Carton Box
	3010300507	2.0 x 1000	5/64 x 39"	5	
	3010300401	2.4 x 1000	3/32 x 39"	5	
	3010300402	3.2 x 1000	1/8 x 39"	5	
	3010300403	4.0 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO

Heat Resisting Arc Welding Wires & Rods

SG CrMo 5

Standards

TS EN ISO 21952-A	: G / W CrMo 5 Si
EN ISO 21952-A	: G / W CrMo 5 Si
AWS A5.28/(A5.9)	: ER 80 S-B6

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr
0.07	0.45	0.5	0.6	6.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
min. 470	min. 590	min. 70 J	min. 18	730-760°C/1h/300°C air

Typical Base Material Grades

- X12CrMo5, GX12CrMo5

Features and Applications

- Used for the welding of high heat resisting steels, hot hydrogen plants, working temperature is +600°C and also used for the welding of steels with 5 Cr 1/2 Mo
- Shielding gases: TIG: pure Ar gas can be used. MAG; Ar+CO₂, and Ar+O₂ mix gases can be used

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010202617	3010202640	0.8	0.030"	15	D 200
3010202619	3010202642	1.0	0.040"	15	D 100
3010202621	3010202644	1.2	0.047"	15	EGO PACK
3010202622	3010202646	1.6	0.062"	15	BIG PACK
		(0,6,0.9, 1.14,1.4)		(1,5,15,18,50,250,400)	
	3010300404	1.6 x 1000	1/16 x 39"	5	Carton Box
	3010300405	2.0 x 1000	5/64 x 39"	5	
	3010300406	2.4 x 1000	3/32 x 39"	5	
	3010300407	3.2 x 1000	1/8 x 39"	5	
	3010300408	4.0 x 1000	5/32 x 39"	5	

Approvals: CE, SEPRO

Heat Resisting Arc Welding Rods

SG CrMo 9V

Standards

TS EN ISO 21952-A	: W CrMo 91
EN ISO 21952-A	: W CrMo 91
AWS A5.28/(A5.9)	: ER 90 S-B9

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr	V	Ni	Nb	N
0.09	0.25	0.6	0.95	9.0	0.2	0.65	0.06	0.05

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))	Heat Treatment
650	740	min. 60 J	min. 18	745-775°C/2h/300°C air

Typical Base Material Grades

- X10CrMoVNb 9-1, A213 Gr. T91, A 335 Gr. P91 (T31), A 139 GR. T91, %9-12 Cr martensitic stainless steels.

Features and Applications

- Used for TIG welding of high heat resistance steels such as P91 / T91
- Power plants, turbines, oil refineries, coal and gasification plants, boiler production, also used for the welding of steels with 9Cr 1Mo
- Weld metal is resistant to working temperature up to 600°C
- Shielding gas (TIG): Pure Ar

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100368	2.00 x 1000	5/64 x 39"	5	Carton Box
6011100369	2.40 x 1000	3/32 x 39"	5	

Approvals: CE, SEPRO

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