

TG 201A

TIG Welding Wire - Creep Resisting Steels

Standards	
AWS/ASME SFA - 5.28	ER80S-D2
EN ISO 21952 - A	W Z MnMo
TS EN ISO 21952 - A	W Z MnMo

Properties and Applications

Low alloyed, GTA (TIG) welding rod for Mo-alloyed creep resisting steels, subjected to operating temperatures up to 530°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
P235G1TH - P255G1TH	St 35.8 - St 45.8
S255N - S460N	StE 255 - StE 460
P235GH, P265GH	H I, H II
P295GH	17Mn4
16Mo3	15 Mo 3
L360NB - L415NB	StE 360.7 - StE 415.7
L360MB - L415MB	StE 360.7 TM - StE 415.7 TM
	X52 - X60

Typical Chemical Features of the Welding Wire				
Type of Analysis	C	Si	Mn	Mo
Welding Wire	0.10	0.70	1.80	0.45

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	540	620	26	20°C → 110 -30°C → 65

* 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)
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
22101GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
22101HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22101IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22101LBKM2	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.