

TG 211

TIG Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER80S-G
EN ISO 21952 - A	W CrMo1Si
TS EN ISO 21952 - A	W CrMo1Si
DIN M. No.	1.7339

Properties and Applications

Low alloyed GTA (TIG) welding rod for Cr-Mo alloyed creep resisting steels, subjected to operating temperatures up to 570°C. Particularly used in root and cap passes 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
13CrMo4-5	13 CrMo 4 4

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.10	0.60	1.00	1.20	0.50

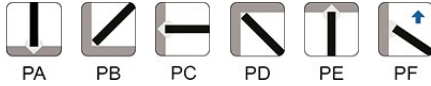
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	510	620	23	20°C → 80	-20°C → 50
Isil İşlem Sonrası (680°C 1 Saat)	I1	500	600	24	20°C → 90	-20°C → 60

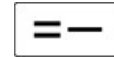
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.00x1000
2.40x1000
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
22102HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22102IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22102LBKM2	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.