

TG 211A

TIG Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER80S-B2
EN ISO 21952 - B	W 55 1CM
TS EN ISO 21952 - B	W 55 1CM

Properties and Applications

Low alloyed, GTA (TIG) welding rod for Cr-Mo alloyed creep resisting steels, subjected to operating temperatures up to 570°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
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	0,50	1.40	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	550	620	21	20°C → 80
Isıl İşlem Sonrası (620°C 2 Saat)	I1	540	600	22	20°C → 100

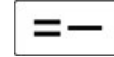
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
1.60x1000
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
22103GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
22103HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22103IBKM2	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.