

标准	AWS A5.28	EN ISO 21952-A	GB/T8110
标号	ER90S-G(ER90S-B3 mod.)	W CrMo2Si	ER62-G

特性及应用范围

- 适用于2.25Cr-1Mo低合金耐热钢钨极氩弧焊；
- 适用于电站锅炉，压力容器，储罐，管线用耐热钢的钨极氩弧焊；
- 专为加氢反应器设计，超低杂质含量，可满足加氢设备步冷试验要求。

适用母材 10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22, SA217Gr. Wc9, ...

	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS	-	-	-	-	-	-	-	-	-	-	-	-
EN	0.04	0.50	0.80	-	-	2.30	0.90	-	-	-	-	-
	0.12	0.80	1.20	0.020	0.020	3.00	1.20	0.30	0.30	-	-	-
*典型值	0.10	0.30	0.65	≤0.010	≤0.010	2.45	1.00	≤0.05	0.15	≤0.005	≤0.005	≤0.003
*X 系数≤15ppm												

全焊缝金属 机械性能 (根据 AWS B4.0M)	焊后热处理 (°C/h)	保护 气体	R _{p0.2}	R _m	A ₄	K _v (J)	
			(MPa)	(MPa)	(%)	+20°C	-30°C
AWS	690/1	I1	≥540	≥620	≥17	-	-
EN	690/1	I1	≥400	≥500	≥18	≥47	-
	690/1	I1	≥540	≥620	≥22	≥55	≥55
保证值	690/6 ⁺²	I1	≥415	515-690	≥22	≥55	≥55
	690/26 ⁺²	I1	≥415	515-690	≥22	≥55	≥55
690/6 ⁺² +步冷 VTr54+3△VTr54≤0							

使用规范 适用焊接位置  电流极性: DC-
保护气体: 符合 EN 439 标准 I1 类纯氩气体
焊丝标识: ※ W III

供货标准	产品编号	规格 (mm)	单位包装形式	单位包装重量 (Kg)
	-	1.0	盘 (S300)	10.0
	-	1.2	盘 (S300)	15.0
	67007	2.0x1000	盒	20.0
	67006	2.4x1000	盒	20.0

Specification Clas. Code	AWS A5.28	EN ISO 21952-A	GB/T8110
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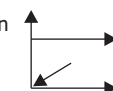
Properties & Application

- GTAW solid rod for the welding of 2.25Cr-1Mo low alloyed and creep resistant steels.
- Applications include the welding of low alloyed and creep resistant steels in boiler, tank, and pipeline.
- Special fabrication for hydrogenation reactor, low impurity content of weld metal, can meet step-cooling requirements of hydrogenation reactor.

Base Metals 10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22, SA217Gr. Wc9, ...

	C	Si	Mn	P	S	Cr	Mo	Cu	Ni	As	Sn	Sb
AWS	-	-	-	-	-	-	-	-	-	-	-	-
EN	0.04	0.50	0.80	-	-	2.30	0.90	-	-	-	-	-
	0.12	0.80	1.20	0.020	0.020	3.00	1.20	0.30	0.30	-	-	-
Typical*	0.10	0.30	0.65	≤0.010	≤0.010	2.45	1.00	≤0.05	0.15	≤0.005	≤0.005	≤0.003
*X-factor≤15ppm												

Mechanical Properties of All Weld Metal (According to AWS B4.0M)	PWHT (°C/h)	Shield Gas	R _{p0.2}	R _m	A ₄	K _v (J)	
			(MPa)	(MPa)	(%)	+20°C	-30°C
AWS	690/1	I1	≥540	≥620	≥17	-	-
EN	690/1	I1	≥400	≥500	≥18	≥47	-
	690/1	I1	≥540	≥620	≥22	≥55	≥55
Guarantee	690/6 ⁺²	I1	≥415	515-690	≥22	≥55	≥55
	690/26 ⁺²	I1	≥415	515-690	≥22	≥55	≥55
690/6 ⁺² +Step-cooling VTr54+3△VTr54≤0							

Operating Data Welding Position  Polarity: DC-
Shielding gas: (EN 439) I1
Wire Mark: ※ W III

Size & Packing	Product No.	Size (mm)	Pack	Kg/pack
	-	1.0	Spool (S300)	10.0
	-	1.2	Spool (S300)	15.0
	67007	2.0x1000	Box	20.0
	67006	2.4x1000	Box	20.0