CARBOFIL CRMO2

TOP FEATURES

- Deposit insensitive to cracking.
- Good radiographic quality.
- Also suitable for the welding of 1¼Cr½Mo steels where improved resistance to hydrogen attack or corrosion by sulphur is required.

TYPICAL APPLICATIONS

- Oil & Gas
- Thermal Power
- Pressure vessels
- Chemical
- Boilers, plates, tubes steels

CLASSIFICATION

AWS A5.28	ER90S-G
EN ISO 21952-A	G CrMo2Si

SHIELDING GASES (ACC. EN ISO 14175)

M20	Mixed gas Ar+ >5-15% CO_2
M21	Mixed gas Ar+ >15-25% CO_2
M24	Mixed gas Ar+ >5-15% CO_2+ >0,5-3% O_2
M26	Mixed gas Ar+ >15-25% CO_2+ >0,5-3%O_2

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Mo
0.09	1.2	0.7	≤0.020	≤0.020	2,5	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	M21	PWHT 690°C x 1h	≥400	≥620	≥18	≥47

*PWHT = Post Welding Heat Treatment

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	16.0	W000282963

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.