

## Low alloy solid rod

### Classification

AWS A5.28 : ER90S-B3\*  
 ISO 21952 : W CrMo2Si

\* Nearest classification

### General description

Solid rod for welding creep and hydrogen resistant Cr-Mo steels  
 Service temperature up to 600°C

### Shielding gases (acc. ISO 14175)

I1 Inert gas Ar (100%)

### Chemical composition (w%) typical wire / rod

C	Mn	Si	Cr	Mo
0.09	1.0	0.6	2.5	0.9

### Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	SR 700°C/1h	560	640	22	140

### Materials to be welded

Steel grades	Code	Type
Creep and hydrogen resistant steels	EN 10028-2	10CrMo 9-10
	EN 10222-2	12CrMo 9-10

### Application advice

Preheating welding joint acc. EN 1011-1, 200-250°C  
 Post weld heat treatment at 690-740°C

### Packaging and available sizes

Unit type	Diameter (mm)		
	2.0	2.4	3.0
2 and 5 kg tube	X	X	X
Other sizes and packaging on request			

LNT 20: rev. EN 21

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request