

CARBO S- CrMo 2

CARBO T- CrMo 2

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	1.7384	
DIN 8575	SG CrMo 2	WSG CrMo 2
AWS SFA-5.28	ER 90 S-G	ER 90 S-G

Approvals

Application notes

Low alloyed wire for welding joints with good mechanical properties to low alloyed quenched and subsequently tempered steels of equal or similar analysis.

The alloy is suitable for tubes resistant to caustic embrittlements for working temperatures up to 600°C.

Operating temperature

20° C up to + 600° C

Base materials

1.7380	10CrMo9-10	1.7259	26CrMo7
1.7375	12CrMo9-10	1.7273	24CrMo10
1.7380	G-12CrMo9-10	1.7276	10CrMo11
1.7379	G-17CrMo9-10	1.7281	16CrMo9-3
1.8075	10CrSiMoV7		

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at -40° C
700	>435	20	100

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Mo
0,07	0,7	1,1	2,8	1,0

Gas types EN 439

S = massive wire

M2, M3, C1

T = bare rod

I1

Current

		= +				= -				
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps	(A) min.	80	120	180	250					
	(A) max.	130	190	250	320					

coils, weight

Rev. 000

B300 15 kg.

25 kg.