

CARBO S- CrMo 2 CARBO T- CrMo 2

International s			S = solid wire				T = bare rod					
		Material No.					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		1.738010CrMo9-101.725926CrMo71.737512CrMo9-101.727324CrMo101.7380G-12CrMo9-101.727610CrMo111.7379G-17CrMo9-101.728116CrMo9-31.807510CrSiMoV710CrSiMoV710CrSiMoV7										
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 0,07	Si 0,7	Mn 1,1	Cr 2,8	Mo 1,0		T:	= hare	rod		
Gas types EN 439			M2, M	3, C1				•	- Darc 1	11		
Current		• •	=	+	4.0			• •	= -			
Welding amps	mm (A) min	0,8	1, 0 120	1 ,2	1, 6 250	1	,0	2,0	2,4	3,2	4,0	
	(A) max.	130	120	250	320							
coils, weight Rev. 001/13		B300	15 kg.			25	5 kg.					

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.