MG-S2CM TRUSTARC™

Solid wire for 2.25%Cr-1%Mo steel

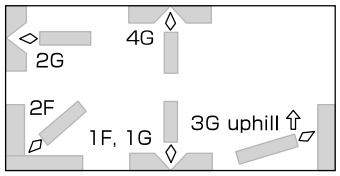
Features: ▪ Applied for ASTM A387 Gr.22 and equivalents

Classification: AWS A5.28 ER90S-B3MnSi

Shielding gas: Ar-2~5%O_2, Ar-5~20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum		
0.9	10kg	-	-	-	-
1.0	10kg	-	-	-	-
1.2	10kg	20kg	100kg	250kg	400kg
1.4	-	20kg	-	250kg	-
1.6	-	20kg	-	-	400kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L	530ϕ, 820H		680ϕ, 770H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.07	0.12
Si	0.56	0.30~0.90
Mn	1.03	0.75~1.40
P	0.005	0.025
S	0.008	0.025
Cr	2.35	2.10~2.70
Mo	1.11	0.90~1.20
Cu	0.17	0.40

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	240~300	130~190

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	580	430	538min.
TS (MPa)	680	570	621min.
El on 4d (%)	23	30	17min.
IV 0℃ (J)	190	140	-
PWHT (℃xh)	690x1	690x15	690±15x1
SG	Ar-2%O_2	Ar-20%CO_2	Ar-2%O_2

Approvals

LR	MG
NK	MG