MG-S2CW TRUSTARC™

Solid wire for low C-2.25%Cr-W-V-Nb steel

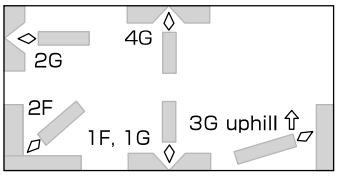
Features: ▪ Applied for ASTM A335 Gr. P23 and equivalents

Classification: AWS A5.28 ER90S-G

Shielding gas: Ar-5~20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	Drum
1.0	10kg	-
1.2	10kg	250kg
Volume mm	240W, 110H, 230L	530ϕ, 820H

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.12
Si	0.38	0.10~0.60
Mn	1.16	0.80~1.60
P	0.003	0.020
S	0.007	0.010
Ni	0.55	0.30~1.00
Cr	2.24	2.00~2.60
Mo	0.10	0.05~0.30
Cu	0.13	0.40
Nb	0.04	0.01~0.08
V	0.27	0.15~0.30
W	1.80	1.00~2.00

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)	660	490min.
TS (MPa)	730	621min.
El on 4d (%)	19	15min.
IV 0℃ (J)	40	-
PWHT (℃xh)	715x2	715x2
SG	Ar-20%CO_2	Ar-20%CO_2

Approvals

LR	MG
NK	MG