MG-S12CRS TRUSTARC™

Solid wire for 9~12%Cr-W-V-Nb steel

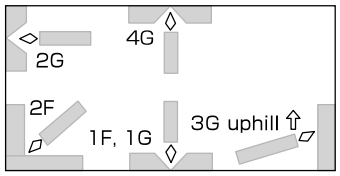
Features: ▪ Applied for ASTM A335 Gr. P92 and equivalents

Classification: AWS A5.28 ER90S-G

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

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	10kg	20kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.12
Si	0.40	0.10~0.70
Mn	1.19	0.80~1.50
P	0.004	0.020
S	0.006	0.020
Ni	0.52	0.30~1.00
Cr	10.10	9.50~11.50
Mo	0.40	0.25~0.50
Cu	0.01	0.40
Nb	0.04	0.01~0.08
V	0.30	0.10~0.50
W	1.59	1.00~2.00
N	0.04	0.02~0.07
Co	1.59	1.00~1.70

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	260~320	140~200

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	590	531min.
TS (MPa)	720	621min.
El on 4d (%)	25	15min.
IV 20℃ (J)	70	-
PWHT (℃xh)	750x8	750±15x1
SG	Ar-5%CO_2	Ar-5%CO_2