PF-200S/US-12CRSD TRUSTARC™

Flux and wire combination for 9~12%Cr-W-V-Nb steel

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

Classification: AWS -

Type of flux: Bonded
Redrying of flux: 200~300℃x1h
Polarity: DCEP

Packaging data

Flux	Mesh	Can	
PF-200S	10x48	20kg	
Volume mm		240W, 350H, 240L	
Wire	**ϕ mm**	**Spool**	**Coil**
US-12CRSD	1.2	20kg	-
	1.6	20kg	-
	2.4	-	25kg
Volume mm		300W, 110H, 300L	430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.07	0.15
Si	0.35	0.50
Mn	0.74	1.00
P	0.004	0.020
S	0.003	0.010
Cu	0.01	1.30
Ni	0.51	0.80
Cr	9.92	9.50~12.00
Mo	0.35	0.10~0.70
W	1.45	1.00~2.00
V	0.21	0.05~0.35
Nb	0.035	0.01~0.10
Co	1.01	0.80~1.20

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.15
Si	0.24	0.60
Mn	0.88	1.50
P	0.008	0.010
S	0.004	0.010
Cu	0.02	0.80
Ni	0.52	1.50
Cr	9.48	8.60~13.00
Mo	0.32	0.10~0.70
W	1.36	1.00~2.00
V	0.20	0.35
Nb	0.030	0.080
Co	0.98	0.50~1.80
N	0.04	0.10

Note: [a] Single values are maximum.

Weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	650	440min.
TS (MPa)	780	621min.
El on 4d (%)	23	17min.
IV 20℃ (J)	30	-
PWHT (℃xh)	745x8	750±15x1