TG-S2CM TRUSTARC™

TIG wire and rod for 2.25%Cr-1%Mo steel

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

Classification: AWS A5.28 ER90S-B3Mn

Shielding Gas: Ar
Identification color: 1st Brown
Polarity: DCEN

Packaging data

	Spool				Tube		
ϕ mm	**kg**				**kg**	**Length mm**	**g/piece**
0.8	1	5	10	-	-	-	-
1.0	-	-	10	-	-	-	-
1.2	-	-	10	20	5	1,000	9
1.6	-	-	10	-	5	1,000	16
2.0	-	-	-	-	5	1,000	25
2.4	-	-	-	-	5	1,000	35
3.2	-	-	-	-	5	1,000	63
Volume mm	280W, 110H, 280L/10pcs	240W, 110H, 230L		280W, 110H, 270L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.11	0.05~0.15
Si	0.36	0.60
Mn	0.70	0.50~1.20
P	0.005	0.025
S	0.008	0.025
Ni	0.04	0.20
Cr	2.29	2.10~2.50
Mo	1.07	0.90~1.20
Cu	0.15	0.35

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	610	538min.
TS (MPa)	720	621min.
El on 4d (%)	28	17min.
IV 0℃ (J)	250	-
PWHT (℃xh)	690x1	690±15x1

Approvals

ABS	MG
LR	MG
DNV	VL2.25Cr1Mo, MG
BV	UP(AWS A5.28 ER90S-G)
NK	MG
KR	MG(AWS A5.28 ER90S-G)