

CEWELD ER 90S (P24) Tig

TYPE	Tig welding wire for creep resistant P/T 24 type of steels.								
APPLICATIONS	The alloy finds use for waterwalls in ultra-super-critical (USC) boilers in the power generating industry.								
PROPERTIES	TIG/GTAW rod for T24 creep resistant steel. The T24 alloy is a modified 2.25%Cr1%Mo alloy with additions of Nb and V to improve high temperature creep performance. Interpass temperature: max. 300°C								
CLASSIFICATION	AWS	A 5.28: ER 90S-G							
	EN ISO	21952-A: W ZCrMo2VNb							
	F-nr	6							
	FM	3							
SUITABLE FOR	alloy 24, 2.5%Cr1%Mo modified, creep resisting ferritic steels. X7CrMoVTiB 10-10 1.7378 / 7CrWVMoNb9-6 - 1.8201 ASTM: A/SA 335 Grade P24 - A/SA 213 Grade T24 A/SA 335 Grade P23 - A/SA 213 Grade T23								
APPROVALS	CE								
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF  PG								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Mo	V	Nb
	0.1	0.25	0.9	0.01	0.01	2.3	1	0.3	0.02
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
					RT				
		730°C- 760°C 1h	650	750	20	50			HRc
REDRYING	Not required								
GAS ACC. EN ISO 14175	I1								