Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

AUTOTHERME Cr-Mo 92

CODIFICATION: **AWS :** SFA 5.28 ER90S-G

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 92 is a copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. The weld metal content 9Cr-1Mo and enriched with Niobium, Vanadium, Nitrogen and tungsten. Tungsten additions provides adequate creep rupture strength at higher steam pressures and temperatures. The controlled addition of alloying elements improves the toughness and weldability. It is specially designed to weld advanced materials, which are being used to improve thermal efficiency in power plant, refineries etc. Ideal for welding steels of similar composition to achieve adequate creep rupture strength. Some typical materials where this electrode can be used are P92, Rotor Steel, E 911 steels, GX12CrMoWVNbW11etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	N	Al	Cu	W
%	0.12	0.42	0.30	0.009	0.007	9.20	0.38	0.95	0.19	0.062	0.043	0.02	0.05	1.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 760^{0}C FOR 2 HRS)

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
800	620	19

WELDING PARAMETER: DC(+)

Diameter	Flat	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/5% Co_2

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.

Note : Please check the drum packing and minimum quantity required before placing the order.