



F Cr-Mo 92

CODIFICATION: AWS : SFA 5.28 ER90S-G

CHARACTERISTICS AND APPLICATIONS:

F Cr-Mo 92 is a copper-coated solid wire for GTAW, 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. Wire 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, E911 steels, GX12CrMoWVNbW11 etc.

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°C FOR 2 HR)

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

SHIELDING GAS: Argon

CURRENT CONDITION: DCEN

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE Diameter 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

QUANTITY 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.

Identification AWS code is punched on each wire.