

IABCO A33 TIG

TIG/GTAW wire low alloy steels

Product name	IABCO A33 TIG
Classification EN ISO	21952-A: W CrMo2Si
Material No.	1.7384
Classification AWS	A5.28: ER90S-G
Approvals	TÜV 12697.00, CE.
Applications	TIG/GTAW rod for high temperature creep resistant 2.25%Cr-1%Mo ferritic steel. These steels are used for creep resisting applications up to ~600°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries. The wire has low levels of tramp elements (eg. Sn, As, Sb & P) providing a low Bruscato (X) Factor for temper embrittlement resistant applications.
Base materials	For matching 2.5%Cr-1%Mo creep resisting ferritic steels. A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22 10CrMo 9-10, G-17CrMo 9-10.
Typical analysis of wire, weight %	C: 0.08 Si: 0.60 Mn: 0.92 Cr: 2.45 Mo: 1.00
Typical heat treatment ⁽¹⁾	Preheat temperature: 200°C. Interpass temperature: 300°C. PWHT: 690°C.
Mechanical properties of weld deposit ⁽²⁾	0.2% proof stress Rp0.2%: ≥540MPa. Tensile strength Rm: ≥620MPa. Elongation 4d/5d: ≥18%.
Other products	SAW: EB3. MIG/GMAW: A33, ER90S-B3. TIG/GTAW: ER90S-B3.

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.