

Classifications

EN ISO 21952-A	AWS A5.28	AWS A5.28M
W MoVSi	ER90S-G	ER62S-G

Characteristics and typical fields of application

GTAW rod specially designed for the base metal 14MoV6-3 (½ Cr ½ Mo ¼ V). Approved in long-term condition up to +560 °C service temperature. Tough, cracking resistant deposit with good creep rupture strength.

Base materials

Similar alloyed creep resistant steels and cast steels
1.7715 14MoV6-3

Typical analysis of the TIG rods (wt.-%)

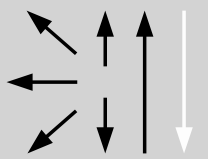
	C	Si	Mn	Cr	Mo	V
wt.-%	0.08	0.6	0.9	0.45	0.85	0.35

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
a	520 (≥ 355)	670 (≥ 620)	24 (≥ 18)	220 (≥ 47)

a annealed, 700 °C/2h / furnace down to 300 °C / air – shielding gas Argon

Operating data

	Polarity: DC (–)	Shielding gas: 100 % Argon	Rod marking: front: ✦ W MoV Si back: 1.5407	ø (mm) 2.4
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Preheating and interpass temperatures 200 – 300 °C. Tempering at 700 – 720 °C at least 2h followed by cooling in furnace down to 300 °C and still air.

Approvals

TÜV (1093.), LTSS, SEPROZ, CE