

MT- Cromo 2

1.7384

MIG/TIG wire of low-alloy chrome-molybdenum-containing steel for welding heat resistant steels, suitable for working temperatures of up to +600°C.

Standard designation

EN ISO 21952-A	G/W CrMo 2 Si
Material No.	1.7384
AWS/ASME SFA-5.28	ER 90 S-G

Main base metals

1.7380	10 CrMo 9 10	1.7273	24 CrMo 10
1.7380	GS - 12 CrMo 9 10	1.7276	10 CrMo 11
1.8075	10 CrSiMo V 7	1.7281	16 CrMo 9 3
1.7259	26 CrMo 7		

Mechanical properties of all – weld – metal

(typical values)

Welding process Gas shield Thermal treatment			TIG I1 ½ h 750°C/air	MIG M11 ½ h 750°C/air
Test temperature		[°C]	+20°C	+20°C
Yielding point	R _{eH}	MPa	460	460
Tensile strength	R _m	MPa	640	640
Elongation	A ₅	[%]	22	22
Impact strength	A _V	[J]	140	140

Average chemical composition

of all-weld-metal (%)

C	Si	Mn	Cr	Mo
0,07	0,7	1,1	2,45	1

Gas types applicable TIG Gas types applicable MIG

I1
M 11, M 21, M 23, M 32

TIG rod diameters available, unit weights

Diameter [mm]	Length [mm]	kgs per box
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,20	1000	25,0

MIG welding wire

Diameter 0,8 mm 1,0 mm 1,2 mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PC, PF

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PD, PE, PF

Current/Polarity TIG

= -

Current/Polarity MIG

= +