

OK Autrod 13.17

A copper coated, low-alloyed, chromium-molybdenum (2,5% Cr, 1,1 % Mo), solid wire for GMAW of creep resistant steels like SA-387 Grade 22, A335 Grade P22 or similar materials. High purity wire with a guaranteed Bruscato factor $X < 15$.

Specifications

Classifications	EN ISO 21952-B : G 62A 2C1M SFA/AWS A5.28 : ER90S-B3
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Shielding Gas	M13, M21 (EN ISO 14175)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
80Ar/20CO₂ (M21) AWS			
Stress Relieved 1 hour(s) 690 °C	590 MPa	720 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
80Ar/20CO₂ (M21) AWS		
Stress Relieved	-40 °C	>47 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.1	0.5	0.5	0.05	2.4	1.0

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	Cu
0.1	0.5	0.5	0.005	0.008	2,4	1.0	0.15

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	120-350 A	20-33 V	2.7-12.4 m/min	1.5-6.6 kg/h