

## Classifications

<b>EN ISO 24598-A</b>	<b>AWS A5.23 / SFA-5.23</b>
S S CrMo2	EB3R

## Characteristics and typical fields of application

Union S 1 CrMo 2 is a copper-coated solid wire for submerged arc welding of creep resistant 2,25%Cr- 1%Mo steel (grade 22) in petro-chemical industry (hydrocrackers).

### Recommended SAW flux:

UV 305  
 UV 420 TT            UV 420 TT-LH  
 UV 420 TTR        UV 420 TTR-C            UV 420 TTR-W

## Base materials

1.7380 10CrMo9-10, 1.7276 10CrMo11, 1.7281 16CrMo9-3, 1.7383 11CrMo9-10, 1.7379 G17CrMo9-10, 1.7382 G19CrMo9-10 ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; 335 Gr. P22; A 336 Gr. F22; A 426 Gr. CP22

## Typical analysis

	C	Si	Mn	Cr	Mo	X
wt.-%	0.12	0.08	0.55	2.5	1.0	< 10

## Operating data

### Dimension mm

1.0  
 1.6  
 2.0  
 2.5  
 3.0  
 4.0  
 5.0

## Approvals

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