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IABCO P24 TIG

TIG/GTAW wire for mild and low alloy steels

Product name	IABCO P24 TIG
Classification EN ISO	21952-A: WZCrMo2VNb
Material No.	-
Classification AWS	A5.28: ER90S-G
Approvals	Under Fliess brand: TÜV 11949.00, CE.
Applications	TIG/GTAW rod for T24 creep resistant steel. The T24 alloy is a modified 2.25%Cr-1%Mo alloy with additions of Nb and V to improve high temperature creep performance. The alloy finds use for waterwalls in ultra-super-critical (USC) boilers in the power generating industry.
Base materials	For matching alloy 24, 2.5%Cr-1%Mo modified, creep resisting ferritic steels. A213 T24 X7CrMoVTiB 10-10.
Typical analysis of wire, weight %	C: 0.10 Si: 0.25 Mn: 0.90 Cr: 2.30 Mo: 1.00 V: 0.30 Nb: 0.02
Typical heat treatment (1)	Preheat temperature: Dependent on application either none or 150-200°C. Interpass temperature: 300°C. PWHT: Dependent on application either AW or 730-760°C.
Mechanical properties of weld deposit (2)	0.2% proof stress Rp0.2%: ≥600MPa. Tensile strength Rm: 700≥Mpa. Elongation 4d/5d: ≥15%.
Other products	SAW: IABCO P24.

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.