

# ES TIG 90S-G

GTAW  
ER90S-G

**ESWECO**  
*The Art of Welding*

## Description

ES TIG 90S-G is a 2.5Cr-1.0Mo-alloyed, copper-coated rod for the GTAW of creep-resistant steels such as pipes in pressure vessels and boilers of similar composition, Steam Generating Power Plant with service temperatures of up to 600°C, but it is also suitable for welding high strength steels.

## Current

DC (-)

## Classifications

SFA/AWS A5.28	ER90S-G
DIN 8575	W.nr 1.7384
EN 12070	W CrMo2Si

## Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.08	0.7	1.0	2.6	1.0

## Typical mech. Properties all weld metal

Yield stress, MPa	>400
Tensile strength, MPa	>500
Elongation, %	>18

## Charpy V

Test temps, °C	Impact values, J
+20	200

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0