

TECHNICAL DATA

Standards

DIN Material Nr. 1.7384

EN ISO 21952-A :	G CrMo2Si
AWS A5.28 :	ER90S-B3 mod.

General Properties / Field of Applications

DSI M Connect 9 is a Laser Welding Wire made of low-alloy chrome-molybdenum steel for welding of 10CrMo9-10 and similar heat-resistant steels for operating temperatures up to 600°C. The weld metal can be tempered and has good strength and toughness values.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	550
Tensile strength R_m	[MPa] / [N/mm ²]	650
Maximum operating temp.	[°C]	600
Elongation A ($L_0 = 5d_0$)	[%]	22

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo
0.1	0.6	1.0	2.4	1.0

Compatible Materials (Selection)

1.7380 10CrMo9-10 / 1.7276 10CrMo11 / 1.7379 G17CrMo9-10
ASTM A 182 Gr. F22 / A 213 Gr. T22 / A355 Gr. P22 / A426 Gr. CP22

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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