

Classifications

EN ISO 21952-A	AWS A5.28	AWS A5.28M
W ZCrCoW11 2 2	ER110S-G	ER76S-G

Characteristics and typical fields of application

BÖHLER C12 CoW-IG is a high alloyed GTAW rod for welding new creep resistant, tempered 11 % chromium steels, especially for the base material VM12-SHC. Scaling resistant up to 650 °C and high creep rupture strength are quality notes for this GTAW rod.

Base materials

VM12-SHC (X12CrCoWVNb12-2-2)

Typical analysis of the TIG rods (wt.-%)

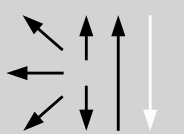
	C	Si	Mn	Cr	Mo	Ni	W	V	N	Co	Nb	B
wt-%	0.13	0.3	0.5	11.2	0.3	0.4	1.6	0.2	0.04	1.5	0.05	0.002

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
a	≥ 620	≥ 760	≥ 15	≥ 40

a annealed, 770 °C/2 h

Operating data

	Polarity:	Shielding gas:	100 % Argon	ø (mm)
	DC (-)	Preheating:	150 – 200°C	
		Interpass temp.:	200 – 280 °C.	
		Rod marking:	front: ✦ W ZCrCoW1122	

Approvals

CE