

**CATEGORY** GTAW Solid wires

**TYPE** Tig welding wire for creep resistant 9% Chromium Alloys.

**APPLICATIONS** Low Alloyed copper-coated solid wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600 °C.

**PROPERTIES** Corrosion resistance is higher than 5Cr-0.5Mo steels requirements. To be used with shielding gas Ar+O<sub>2</sub>.

**CLASSIFICATION**

AWS	A 5.28: ER 80S-B8
EN ISO	21952-A: W CrMo9
F-nr	6
FM	3

**SUITABLE FOR** For matching 9%Cr-1%Mo creep resisting martensitic steels  
 ASTM: A182 Gr F9, A199 Gr T9 , A213 Gr T9 , A217 Gr C12 , A234 Gr WP9, A335 Gr 9, A336 Gr F9, A387 Gr 9,  
 EN: BS 3100 Gr B6, BS 3604 Gr CFS 629-470, HFS 629-470, BS 3604 Gr HFS 629-590, CFS 629-590, GS-12CrCrMo 10-1, X12CrMo 9-1  
 W.Nr: 1.7386, 1.7388, 1.7389

**APPROVALS** CE

**WELDING POSITIONS:**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Mo
0.08	0.41	0.52	8.79	0.97

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V RT
730°C- 760°C /1h	500	600	23	60

**WELDING PARAMETERS / PACKING**

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	PACKING
		CURRENT (A) (DC-)	
1.6 X 1000 MM		50 - 90	5 KG CARTONS
2.4 X 1000 MM		80 - 200	5 KG CARTONS
3.2 X 1000 MM		120 - 250	5 KG CARTONS

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1