

CATEGORY	SAW Arc Submerged	
TYPE	Medium alloyed, high-strength 9% Chromium alloy SAW wire.	
APPLICATIONS	Low alloyed copper-coated SAW wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petrol-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	The 9%Cr-1%Mo creep resistant alloy is used for service up to ~600°C particularly in environments involving hot hydrogen gas. Flux CEWELD® FL 880	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.23: EB8 24598-A: S CrMo9 6 4
SUITABLE FOR	ASTM: A 182 Gr F9, A 199 Gr T9 , A 213 Gr T9 , A 217 Gr C12 , A 234 Gr WP9, A 335 Gr 9 , A 336 Gr F9 , A 387 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) , (DIN GS-12CrCrMo 10-1) , (DIN X12CrMo 9-1) , (DIN X7CrMo 9-1) W.Nr: 1.7386, 1.7388, 1.7389	
APPROVALS	CE	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.4	0.6	0.01	0.01	8.7	0.18	1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
730°C- 760°C /1h	540	660	19	55

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) (DC+)	SPOOL TYPE	KG / SPOOL / DRUM
2.0	26-29	280-375	K-415 / DRUM	25 / 300
2.4	27-30	320-420	K-415 / DRUM	15 / 300
3.2	27-30	400-520	K-415 / DRUM	15 / 300

REDRYING TEMPERATURE	Not required
----------------------	--------------

GAS ACCORDING EN 14175	
------------------------	--