

SAS 9CrMo

SAW

9Cr-1Mo CREEP RESISTING STEEL SAW WIRE

LOW ALLOY STEELS

PRODUCT DESCRIPTION

Solid wire for Sub Arc Welding of 9Cr-1Mo creep resisting steels

CLASSIFICATIONS

AWS A5.23M EB8
ISO 24598-A S CrMo9

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No 5

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min.	0.06	0.40	0.30	--	--	8.5	--	0.80	--
Max.	0.10	0.60	0.50	0.020	0.020	10.0	0.5	1.20	0.35
Typical	0.07	0.5	0.4	0.01	0.015	9	0.1	0.9	0.1

ALL-WELD MECHANICAL PROPERTIES

PWHT	Req.	760°/2h
Tensile strength [MPa]	590-700	698
0.2% proof strength [MPa]	470	573
Elongation [%] 4d	20	22
5d	18	19
Impact ISO-V(U) +20°C	34	100
Hardness cap/mid [HV]	--	

PWHT: AWS is 745 +/- 15°C /1h, ISO is 740-780°C/2h. See front page under PWHT for normal fabrication practice. Obtained with flux LA436.

TYPICAL OPERATING PARAMETERS

Current: DC or AC; DC+ve is preferred
For 2.4mm: 300-500A, 28-36V, 350-700mm/min travel

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SA9CrMo-24