

## 9CrMo

TIG (GTAW)

## 9Cr-1Mo CREEP RESISTING STEEL TIG WIRE

## PRODUCT DESCRIPTION

Solid Wire for TIG

## CLASSIFICATIONS

AWS A5.28M ER80S-B8  
ISO 21952-A W 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 | 0.50 | 1.20 | 0.35 |
| Typical | 0.07 | 0.50 | 0.40 | 0.01  | 0.015 | 9.0  | 0.10 | 0.90 | 0.10 |

## ALL-WELD MECHANICAL PROPERTIES

| Properties after PWHT     | Min. | Typical 745°C/1h |
|---------------------------|------|------------------|
| Tensile strength [MPa]    | 590  | 730              |
| 0.2% proof strength [MPa] | 470  | 612              |
| Elongation [%] 4d         | 17   | 27               |
| 5d                        | 18   | 23               |
| Impact ISO-V(J) +20°C     | --   | 80               |
| Hardness cap/mid [HV]     | --   | 225/230          |

## TYPICAL OPERATING PARAMETERS

| Shielding gas | Current | Diameter (mm) | Parameters |
|---------------|---------|---------------|------------|
| Argon*        | DC-     | 2.4           | 140A, 14V  |

\* Argon is also required as a purging gas for root runs.

## PACKAGING DATA

| Diameter (mm) | Weight (kg) | Packaging | Item number |
|---------------|-------------|-----------|-------------|
| 1.6           | 5           | PE TUBE   | T9CRMO-16   |
| 2.4           | 5           | PE TUBE   | T9CRMO-24   |
| 3.2           | 5           | PE TUBE   | T9CRMO-32   |