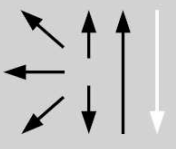


Classifications					
EN ISO 21952-A	EN ISO 21952-B	AWS A5.28	AWS A5.28M		
W CrMo9Si	W 55 I1 9C1M	ER80S-B8	ER55S-B8		
Characteristics and typical fields of application					
GTAW rod for 9 % Cr 1 % Mo creep resistant steels and steels for hot hydrogen service, particularly for application in oil refineries and the base metals X12CrMo9-1 (P9). Approved in long-term condition up to +600 °C service temperature.					
Base materials					
Similar alloyed creep resistant steels 1.7386 X11CrMo9-1, 1.7388 X7CrMo9-1 ASTM A 182 Gr. F9; A 213 Gr. T9; A 217 Gr. C12; A 234 Gr. WP9; A 335 Gr. P9; A 336 Gr. F9; A 369 Gr. FB9; A 387 Gr. 9 u. 9CR; A 426 Gr. CP9; A 989 Gr. K90941					
Typical analysis of the TIG rods (wt.-%)					
	C	Si	Mn	Cr	Mo
wt.-%	0.07	0.4	0.5	9.0	1.0
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	530 (≥ 470)	670 (≥ 590)	24 (≥ 18)	220 (≥ 34)	
a annealed 760 °C / 2 h / furnace down to 300 °C / air – shielding gas Argon					
Operating data					
	Polarity: DC (-)	Shielding gas: 100 % Argon	Rod marking: front: † W CrMo9 Si back: ER80S-B8	ø (mm) 2.4	
Preheating and interpass temperature 250 – 350 °C. Tempering at 710 – 760 °C for at least 1 h followed by cooling in furnace down to 300 °C/air. For detailed information about the welding technology please contact our service departments.					
Approvals					
TÜV (2182.), SEPROZ, CE					