

Gas Tungsten Arc Welding

TG-S9CM
FAMILIARC
TIG welding rod and wire for 9%Cr-1%Mo heat resistant steel
Classification: ASME / AWS A5.28 ER80S-B8

Features: Applied for ASTM A387 Gr.9 and equivalents

Shielding Gas: Ar

Polarity: DC-EN

Chemical composition of rod and wire (%) as per AWS

	C	Si	Mn	P	S	Cr
Example	0.07	0.39	0.52	0.006	0.009	8.98
Guaranty	≤0.10	≤0.50	0.40~0.70	≤0.025	≤0.025	8.00~10.5
	Mo	Ni	Cu			
Example	1.00	0.18	0.01			
Guaranty	0.8~1.2	≤0.50	≤0.35			

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cx h)
Example	410	590	32	0°C: 220	750x2
Guaranty	≥470	≥550	≥17	-	745±15x1

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g)
1.2	spool	20	-	-
1.6	tube	5	1,000	16
2.0	tube	5	1,000	25
2.4	tube	5	1,000	35
3.2	tube	5	1,000	63