

Gas Tungsten Arc Welding

TG-S9Cb
FAMILIARC
TIG welding rod and wire for 9%Cr-1%Mo-Nb-V heat resistant steel
Classification: ASME / AWS A5.28 ER90S-G

Features :

- Applied for ASTM A387 Gr.91 and equivalents
- Excellent creep rupture strength

Shielding Gas: Ar

Polarity: DC-EN

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

	C	Si	Mn	P	S	Cr
Example	0.08	0.16	1.01	0.006	0.005	9.01
Guaranty	≤0.12	≤0.60	≤1.20	≤0.020	≤0.010	8.00~10.00
	Mo	Ni	Nb	V	Cu	
Example	0.90	0.71	0.04	0.18	0.01	
Guaranty	0.85~1.20	≤0.80	0.02~0.12	0.10~0.35	≤0.35	

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cx h)
Example	700	780	24	0°C: 240	740x8
Guaranty	≥410	≥620	≥16	-	745±15x1

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g)
0.8	spool	10	-	-
1.0	spool	10	-	-
1.2	spool	10	-	-
1.6	spool	10	-	-
	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