

**TIG wire and rod for 9%Cr-1%Mo-Nb-V steel**

**Features:**

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

**Classification:** AWS A5.28 ER90S-G

**Shielding Gas:** Ar

**Identification color:** 1st Gray

**Polarity:** DCEN

**Packaging data**

φ mm	Spool		Tube		
	kg		kg	Length mm	g/piece
0.8	5	10	-	-	-
1.0	-	10	-	-	-
1.2	-	10	-	-	-
1.6	-	10	5	1,000	16
2.0	-	-	5	1,000	25
2.4	-	-	5	1,000	35
3.2	-	-	5	1,000	63
<b>Volume mm</b>	240W, 110H, 230L		40W, 35H, 1015L		

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.12
<b>Si</b>	0.16	0.50
<b>Mn</b>	1.00	0.50~1.20
<b>P</b>	0.006	0.020
<b>S</b>	0.004	0.010
<b>Ni</b>	0.67	0.10~0.80
<b>Cr</b>	8.98	8.00~10.00
<b>Mo</b>	0.88	0.85~1.20
<b>Nb</b>	0.04	0.02~0.12
<b>V</b>	0.18	0.10~0.35
<b>Cu</b>	0.03	0.35
<b>N</b>	0.02	0.01~0.05

Note: <sup>a</sup>Single values are maximum.

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	700	414min.
<b>TS (MPa)</b>	780	621min.
<b>El on 4d (%)</b>	24	16min.
<b>IV 0°C (J)</b>	240	-
<b>PWHT (°C×h)</b>	740x8	745±15x1

**Approvals**

<b>LR</b>	MG
<b>NK</b>	MG