

Filler rod and wire

Features:	▪ Suitable for 9% Ni steel
Classification:	AWS A5.14 ERNiMo-8
Shielding gas:	Ar
Identification color:	1st Orange
Polarity:	DCEN

Packaging data

ϕ mm	Spool			Tube		
	kg			kg	Length mm	g/piece
1.2	10	15	20	5	1,000	11
1.6	10	15	-	5	1,000	19
2.0	-	-	-	5	1,000	29
2.4	-	-	-	5	1,000	42
Volume mm	240W, 110H, 240L	285W, 110H, 285L		40W, 35H, 1015L		

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.02	0.10
Si	0.02	0.50
Mn	<0.1	1.0
P	0.001	0.015
S	0.001	0.015
Ni	69.8	60.0min.
Cr	2.0	0.5~3.5
Mo	19.1	18.0~21.0
W	3.0	2.0~4.0
Fe	5.6	10.0
Cu	0.01	0.50

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	460	-
TS (MPa)	730	660min.
EI on 4d (%)	47	25min.
IV -196°C (J)	160	-

Approvals

NK	KSWL92G (I)
-----------	-------------