

9CrMoV

TIG (GTAW)

SOLID WIRE WITH LOW Ni CONTENT FOR TIG

PRODUCT DESCRIPTION

Solid wire with Mn+Ni≤1.0%, non-copper coated, for TIG

CLASSIFICATIONS

AWS A5.28M	ER90S-B9
ISO 21952-B	W 9Cr1MV
ISO 24598-B	W 9Cr1MV

ASME IX QUALIFICATION

QW422	P-No 15E group 1
QW432	F-No 6
QW442	A-No 5

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	V	N	Cu	Al
Min.	0.08	0.40	0.15	--	--	8.5	0.10	0.85	0.03	0.15	0.03	--	--
Max.	0.13	0.80	0.50	0.010	0.010	9.5	0.40	1.10	0.08	0.25	0.07	0.10	0.04
Typical	0.10	0.5	0.35	0.004	0.008	9.0	0.3	1.0	0.05	0.2	0.05	0.03	<0.01

* Mn+Ni≤1. 0%. Nickel is below 0.4% (as parent material) although AWS allows up to 1.0%Ni.
See 9CrMoV-N for variant with 0.4–0.8%Ni conforming to ISO suffix "A" specification.

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.	Typical (760°C / 2h)
Tensile strength (MPa)	620	760
0.2% proof strength (MPa)	415	650
Elongation (%) 4d	16	22
5d	15	19
Reduction of area (%)	--	70
Hardness (HV) (mid)	--	255

* Minimum impact required by ISO is 47 J.

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.0	5	PE TUBE	T9CRM0V-20
2.4	5	PE TUBE	T9CRM0V-24
3.2	5	PE TUBE	T9CRM0V-32