# F Cr-Mo 9

**CODIFICATION:**

**AWS :** SFA 5.28 ER80S-B8
EN ISO : 21952-B-W I1 9C1M

## CHARACTERISTICS AND APPLICATIONS:

F Cr-Mo 9 is a copper-coated solid wire for GTAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is designed for creep resistant steels. It is used for welding base metal of similar compositions, usually in the form of pipe or tubing. Typical applications include welding of A387 Grade 9 plate, A335 P9 pipe, A213 T9 tubes, etc.

## TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

| Element | C | Mn | Si | S | P | Cr | Mo | Cu |
|---|---|---|---|---|---|---|---|---|
| % | 0.08 | 0.60 | 0.30 | 0.020 | 0.020 | 9.00 | 1.00 | 0.10 |

## TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

**(PWHT: 745°C FOR 1 HR)**

| UTS (MPa) | YS (MPa) | Elongation (L = 5d) % |
|---|---|---|
| 570 | 500 | 18 |

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

**WELDING POSITION:** H, F, VU, OH

**APPROVAL :** CE

**PACKING:**

| | |
|---|---|
| STANDARD SIZE | Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each. |
| QUANTITY | 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on each wire. |