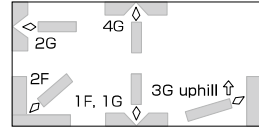


**Solid wire for 9-12%Cr-W-V-Nb steel****Features:** Applied for ASTM A335 Gr. P92 and equivalents**Welding Positions:****Classification:** AWS A5.28 ER90S-G**Shielding gas:** Ar-2~5%O<sub>2</sub>, Ar-5~20%CO<sub>2</sub>**Polarity:** DCEP**Packaging data**

$\phi$ mm	Spool	
1.2	10kg	20kg
<b>Volume mm</b>	240W, 110H, 230L	280W, 110H, 270L

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.12
<b>Si</b>	0.40	0.10~0.70
<b>Mn</b>	1.19	0.80~1.50
<b>P</b>	0.004	0.020
<b>S</b>	0.006	0.020
<b>Ni</b>	0.52	0.30~1.00
<b>Cr</b>	10.10	9.50~11.50
<b>Mo</b>	0.40	0.25~0.50
<b>Cu</b>	0.01	0.40
<b>Nb</b>	0.04	0.01~0.08
<b>V</b>	0.30	0.10~0.50
<b>W</b>	1.59	1.00~2.00
<b>N</b>	0.04	0.02~0.07
<b>Co</b>	1.59	1.00~1.70

**Welding parameters (A)**

$\phi$ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	260~320	140~200

Note: <sup>a</sup>Single values are maximum.**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	590	531min.
<b>TS (MPa)</b>	720	621min.
<b>El on 4d (%)</b>	25	15min.
<b>IV 20°C (J)</b>	70	-
<b>PWHT (°C×h)</b>	750×8	750±15×1
<b>SG</b>	Ar-5%CO <sub>2</sub>	Ar-5%CO <sub>2</sub>