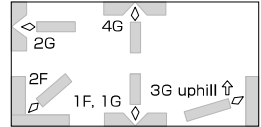


Solid wire for 9%Cr-1%Mo-V-Nb steel**Features:** ▪ Applied for ASTM A387 Gr.91 and equivalents**Classification:** AWS A5.28 ER90S-G**Shielding gas:** Ar-2~5%O₂, Ar-5~20%CO₂**Polarity:** DCEP**Welding Positions:****Packaging data**

φ mm	Spool	
1.0	10kg	-
1.2	10kg	20kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.08	0.12
Si	0.32	0.10~0.60
Mn	1.54	1.20~1.90
P	0.005	0.020
S	0.007	0.020
Ni	0.45	0.20~1.00
Cr	8.79	8.00~10.50
Mo	0.86	0.80~1.20
Cu	0.09	0.35
Nb	0.02	0.01~0.10
V	0.17	0.15~0.50
N	0.02	0.01~0.05

Note: ^a Single values are maximum.**Welding parameters (A)**

φ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	260~320	140~200

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	570	414min.
TS (MPa)	700	621min.
El on 4d (%)	27	15min.
IV 0°C (J)	100	-
PWHT (°C×h)	740x8	745±15x1
SG	Ar-5%CO ₂	Ar-5%CO ₂

Approvals

ABS	MG (AWS A5.28 ER90S-G)
LR	MG
NK	MG