

TIGFIL 90S-B9

Classification

AWSA/SFA5.28 : ER90S-B9

Identification: AWS classification embossed at one end of the wire.

Characteristics

A GTAW filler/rod with weld metal deposit of 9 Cr - 1 Mo type with alloying additions for P91/T91 materials. The filler wire can be used for obtaining good X-ray quality joints.

Typical Applications

For welding of 9Cr-1Mo steels like P91/T91.

Wire Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr	Cu	V	Al	Ni
0.07-0.12	1.2 max	0.15-0.50	0.010 max	0.010 max	0.85-1.20	8-10.5	0.20 max	0.15-0.30	0.04 max	0.80 max

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

All Weld Mechanical Properties After PWHT at 760±15°C for 2 hr.

UTS MPa	620 min.
Yield strength MPa	410 min.
Elongation % (L=4xd)	16 min.
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.	

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



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