Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1966 - 2016

AUTOTHERME Cr-Mo 9

CODIFICATION: **AWS :** SFA 5.28 ER80S-B8

CHARACTERISTICS AND APPLICATIONS:

Autotherme Cr-Mo 9 is a copper-coated solid wire for GMAW, 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^{0}C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
570	500	18

WELDING PARAMETER: DC(+)

Diameter	**Flat**	
	Volt, V	Current, A
1.2 mm	27-32	300-360
1.6 mm	25-30	340-420

SHIELDING GAS: Argon/ 1-5% O_2

WELDING POSITION: H, F, VU, OH

PACKING :

STANDARD SIZE	1.2 mm & 1.6 mm.
QUANTITY	15.0 kg wire, layer wound in a plastic spool that conforms to DIN-8559 SD-300.