# TG-S709S PREMIARC™

**Filler rod and wire**

**Features:** ▪ Suitable for 9% Ni steel

**Classification:** AWS A5.14 ERNiMo-8

**Shielding gas:** Ar
**Identification color:** 1st Orange
**Polarity:** DCEN

## Packaging data

| | Spool | | | Tube | | |
|---|---|---|---|---|---|---|
| **ϕ mm** | **kg** | | | **kg** | **Length mm** | **g/piece** |
| 1.2 | 10 | 15 | 20 | 5 | 1,000 | 11 |
| 1.6 | 10 | 15 | - | 5 | 1,000 | 19 |
| 2.0 | - | - | - | 5 | 1,000 | 29 |
| 2.4 | - | - | - | 5 | 1,000 | 42 |
| **Volume mm** | 240W, 110H, 240L | 285W, 110H, 285L | | 40W, 35H, 1015L | | |

## Composition (rod and wire mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| **C** | 0.02 | 0.10 |
| **Si** | 0.02 | 0.50 |
| **Mn** | <0.1 | 1.0 |
| **P** | 0.001 | 0.015 |
| **S** | 0.001 | 0.015 |
| **Ni** | 69.8 | 60.0min. |
| **Cr** | 2.0 | 0.5~3.5 |
| **Mo** | 19.1 | 18.0~21.0 |
| **W** | 3.0 | 2.0~4.0 |
| **Fe** | 5.6 | 10.0 |
| **Cu** | 0.01 | 0.50 |

Note: [a] Single values are maximum.

## All-weld mechanical properties

| | Typical | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 460 | - |
| **TS (MPa)** | 730 | 660min. |
| **El on 4d (%)** | 47 | 25min. |
| **IV -196℃ (J)** | 160 | - |

## Approvals

| | |
|---|---|
| **ABS** | MG (AWS A5.14 ERNiMo-8) |
| **LR** | 9Nim |
| **DNV** | MS (9Ni) |
| **BV** | Equivalent to AWS A5.14 ERNiMo-8 |
| **NK** | KSWL92G (Ⅰ) |