MG-S9Cb TRUSTARC™

Solid wire for 9%Cr-1%Mo-V-Nb steel

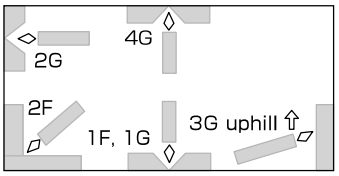
Features: ▪ Applied for ASTM A387 Gr.91 and equivalents

Classification: AWS A5.28 ER90S-B91CMn

Shielding gas: Ar-2~5%O_2, Ar-5~20%CO_2

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℃ (J)	100	-
PWHT (℃xh)	740x8	745±15x1
SG	Ar-5%CO_2	Ar-5%CO_2

Approvals

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