

MIG-MAG Wires C-Mn and low-alloy steels

Carbofil CrMo9 is a copper coated solid wire used for the welding of creep resistant steels containing 9%Cr and 1%Mo. During welding preheat and interpass temperature controls between 250-300°C are recommended.

Classification	
AWS	A5.28: ER 80S-B8
EN	12070: G CrMo9

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.06	0.70	0.50	≤ 0.025	≤ 0.025	9	0.06	1	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) +20°C	Hardness
PWHT 760°C x 2h	≥ 470	≥ 590	≥ 18	≥ 34	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

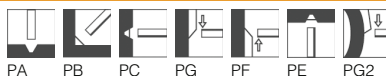
A335 Gr. P9

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC +



Packaging data: K300 Kg. 16

Diameters	1,2					
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