

Cryo-Shield Ni9

Flux cored wire for welding of 9% Ni steel. Cryo-Shield Ni9 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ shielding gas. This weld metal is a Nickel-based with excellent crack resistance and less sensitive to weld bead surface porosity.

Specifications

Approvals

ABS : Manufacturer Guarantee
 BV : Equivalent to N90
 CCS : 9Ni
 DNV-GL : - MS
 KR : L 91SG(C)
 LR : 9Ni

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current

DC+

Alloy Type

Ni Cr Mo

Shielding Gas

C1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
C1			
As Welded	440 MPa	730 MPa	44 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
C1		
As Welded	-196 °C	65 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti
CO₂ Shielding gas									
0.02	1.45	0.45	0.002	0.01	58.5	19.0	8.15	0.01	0.12

Typical Weld Metal Analysis %

Fe	Nb+Ta
CO₂ Shielding gas	
9.0	3.00

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h