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