



# CEWELD SG CrMnMo Tig

|                |                                                                                                                                                                 |                               |  |
|----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|--|
| TYPE           | 8CrMo12 filler metal for welding similar type of steels. (Air 9117 - 8CD12)                                                                                     |                               |  |
| APPLICATIONS   | CEWELD CrMnMo Tig finds its application in the aerospace and motorsports industries, and also in the repair of some tool steels. According AIR 9117 and LN 9425 |                               |  |
| PROPRIÉTÉS     | CEWELD® SG CrMnMo EN 4332: FE-WL1805 (8CrMnMo12-4-9) wire is used for welding matching, and similar, composition base materials.                                |                               |  |
| CLASSIFICATION | AWS<br>W.Nr.                                                                                                                                                    | A 5.28: ~ER 90S-B3<br>WL 1805 |  |
| CONVIENT POUR  | 30CrMoV12, 55NiCrMoV7, 55CrNiMo4                                                                                                                                |                               |  |

## AGRÉMENTS

## POSITIONS DE SOUDAGE



## ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

| C    | Si  | Mn  | P    | S    | Cr  | Mo |
|------|-----|-----|------|------|-----|----|
| 0.06 | 0.7 | 1.1 | 0.08 | 0.08 | 2.7 | 1  |

## PROPRIÉTÉS MÉCANIQUES

| Heat<br>Treatment | R <sub>p0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V | Hardness |
|-------------------|----------------------------|-------------------------|-----------|-------------------------|----------|
|                   |                            |                         |           | RT                      |          |
| 720°C±15°C 2h     | 440                        | 570                     | 24        | 80                      | 36 HRc   |

ETUVAGE Not required

GAS ACC. EN ISO 14175 I1