

## 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% CO<sub>2</sub> shielding gas. This welding material is a Nickel-based with excellent crack resistance and anti-porosity on the weld bead surface.

<b>Approvals</b>	ABS Manufacturer Guarantee
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*Approvals are based on factory location. Please contact ESAB for more information.*

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Ni Cr Mo
<b>Shielding Gas</b>	C1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>CO<sub>2</sub> Shielding gas</b>			
As Welded	440 MPa	730 MPa	44 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>CO<sub>2</sub> Shielding gas</b>		
As Welded	-196 °C	65 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti
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
9.0	3.00

### Deposition Data

Diameter	Current	Voltage	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