



### Characteristics and scope of application

- Filler metal for 9% Ni steels in cryogenic applications e. g. LNG tanks
- Excellent strength down to -321°F

### Standard designations

DIN DIN EN ISO 18274	AWS 5.14	DIN Mat.-No.
S Ni 1008 (NiMo19WCr)	ERNiMo-8	-

### Typical chemical composition of filler metal

	C	Si	Mn	Cr	Ni	Mo	Fe	W	Al	Ti
Mass %	0.03	0.15	0.2	2.0	Bal.	19	6.0	3.0	0.2	0.2

### All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	62 ksi	104 ksi	35%	100 J	100 J / -321°F

### Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A
DC / -	SG-A

Low heat input and interpass temperature. Stringer bead technique recommended.

#### Base materials

1.5662, 1.5663

ASTM A 333 Gr. 8

ASTM A 353 – UNS K81340

ASTM A 553 – UNS K81340

### Packaging (tolerances acc. to AWS A5.02)

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55

Approvals on request