



### Characteristics and scope of application

- Filler metal for 9% Ni steels in cryogenic applications e. g. LNG tanks
- Excellent strength down to -196°C

### 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	430 MPa	720 MPa	35%	100 J	100 J / -196°C

### Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1
DC / -	I1

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 DIN EN ISO 544)

Approvals on request

Diameter (mm)		kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25