

SR-08

Conformances

AWS A5.11/ ASME SFA5.11 ENiMo-8

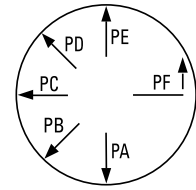
Applications

- Repair welding and tack welding of 9%Ni steel
- LNG Storage tanks

Features

- Good impact toughness at extra low temperature

Welding Position



Current

AC

Diameter / Packaging

Diameter	Length mm(in)
mm (in)	350 (14)
2.6 (3/32)	
3.2 (1/8)	✓
4.0 (5/32)	✓
5.0 (3/16)	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	W	Fe
0.03	0.25	0.3	0.002	0.001	2.6	67.0	18.5	3.1	6.0

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
-	730 (106,000)	41.0	-196 (-321)	70 (52)

Typical Welding Parameters

Approx. Current (Amps)		
Diameter	3.2mm (1/8) AC	4.0mm (5/32) AC
F	70-90	110-140
V-up	70-90	100-130

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX