



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						
PROPERTIES	CEWELD® SG CrMnMo EN 4332: FE-WL1805 (8CrMnMo12-4-9) wire is used for welding matching, and similar, composition base materials.						
CLASSIFICATION	AWS W.Nr.	A 5.28: ~ER 90S-B3 WL 1805					
SUITABLE FOR	30CrMoV12, 55NiCrMoV7, 55CrNiMo4						
APPROVALS							
WELDING POSITIONS	      						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.06	0.7	1.1	0.08	0.08	2.7	1
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT		
	720°C±15°C 2h	440	570	24	80		36 HRc
REDRYING	Not required						
GAS ACC. EN ISO 14175	I1						