



AWS A5.9/A5.28: ER90S-B8  
BS 2901 Pt1: A35(obs)-~

## TIG/MIG Filler Wire

9Cr/Mo Steels with other Chrome Moly

**CMW-1990**

### DESCRIPTION & APPLICATION

TIG/MIG Filler Wire for the joining or overlay of 9% Chrome/Moly steels such as used for creep resistant service up to 500°C. Offers corrosion resistance to steam, hot hydrogen gases and high sulphur content crude oil.

### BASE MATERIALS

BS 1504 Gr 629 BS 3100 B6 (cast)  
ASTM A336, A335, A199, A200, A213 Gr T9  
Din 1.7368, 1.7386, 1.7388, 1.7389

### MECHANICAL PROPERTIES

>600

UTS n/mm

>500

YIELD 0.2%

>20

ELONG A5%

>40

IMPACT (J) 20°C

### METAL WELD COMPOSITION %

**C**

0.07

**Si**

0.3

**Mn**

0.5

**S**

0.01

**P**

0.015

**Cr**

9.0

**Mo**

0.9

**Fe**

BAL

### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

### DIAMETERS

1.6, 2.4, 3.2mm (TIG)  
0.8, 1.0, 1.2mm (MIG)

### WELDING INSTRUCTIONS

Preheat as per the requirements of the base material.