BÖHLER CN 19/9 M-IG

TIG rod, high-alloyed, special applications

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
W 20 10 3	SS(308Mo)	ER308Mo (mod.)

Characteristics and typical fields of application

GTAW rod of type W 20 10 3 / 308Mo. This rod is designed for dissimilar joints and weld cladding.

BÖHLER CN 19/9 M-IG offers a lower chromium and ferrite content than a 309L weld deposit with the result that carbon diffusion and Cr-carbide formation is reduced after post weld heat treatment and lower ferrite contents can be achieved in the second layer of 316L surfacing.

Suitable for service temperatures from –80 °C to +300 °C.

Very good welding and wetting characteristics.

Base materials

High-strength, mild steels and low-alloyed constructional steels, QT-steels and armour plates among themselves or among each other; non-alloy as well as alloyed boiler or constructional steels with high-alloy stainless Cr- and Cr-Ni-steels; austenitic manganese steels similar and dissimilar.

Typical analysis of the TIG rods (wt.-%)

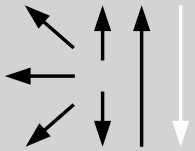
	C	Si	Mn	Cr	Ni	Mo
wt-%	0.05	0.7	1.2	20.0	10.0	3.2

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–80 °C
u	**540** (≥ 400)	**710** (≥ 620)	**35** (≥ 20)	**200**	≥ 32

u untreated, as welded – shielding gas Argon

Operating data



Polarity:	Shielding gas:	Rod marking:	ø (mm)
DC (–)	100 % Argon	front: W 20 10 3 back: 1.4431	1.6 2.0 2.4 3.2

Preheating and interpass temperature as required by the base metal.

Approvals

TÜV (0427.), DNV (308Mo), CE