



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 A 5.28: ~ER 90S-B3
W.Nr. 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