

SR-134

Conformances

AWS A5.11/ ASME SFA5.11 ENiCrFe-4
 JIS Z3225 D9Ni-1
 KOGAS
 DNV-GL VL9Ni H5

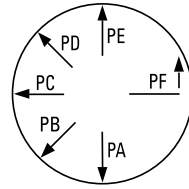
Applications

- 9%Ni steel for cryogenic storage tanks for LNG
- Liquified nitrogen tanks

Features

- Good strength and toughness at cryogenic temperatures
- Meets specifications of API and NV for the welding of 9%Ni steel With AC

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	Nb	Fe
0.07	0.4	2.8	0.01	0.02	15.5	70.7	2.2	2.2	5.3

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)
-	705 (102,000)	40.5	-196 (-321)	58 (43)

Typical Welding Parameters

Diameter	Approx. Current (Amps)		
	3.2mm (1/8) AC	4.0mm (5/32) AC	5.0mm (3/16) AC
F	70~90	110~140	120~150
V-up	70~90	100~130	110~140