



# 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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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