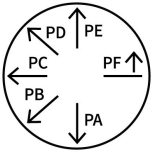
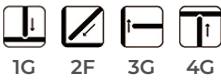


SR-134

Classification

AWS A5.11/ASME SFA-5.11 ENiCrFe-4
JIS Z 3225 D9Ni-1

Welding Positions



Features

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

Polarity

AC

Application Areas

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

Redrying Conditions

300~350°C (572~662°F) X 1hr

Approvals

DNV	KOGAS
✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	Fe
0.10	0.5	3.0	0.003	0.002	66.4	15.7	2.5	10.3

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
705(102)	40	-196(-320)	58(43)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	300 (12)	70~90	70~90	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
3.2 (1/8)	350 (14)	110~140	100~130	
4.0 (5/32)	350 (14)	120~150	110~140	
5.0 (3/16)	350 (14)			