

SM-9010 / ST-9010

Conformances

JIS Z3341 YCuNi-1
KR KS D7044 YCuNi-1

Applications

- Desalination plant
- Offshore applications for ship building in the chemical industry

Features

- No preheat & PWHT required, maximum interpass temperature 150°C
- Contamination of the weld zone with foreign material, particularly any source of lead, tin or zinc must be scrupulously avoided to prevent weld metal cracking

Welding Position

Current

GMAW: DC+(Pulse)
GTAW: DC-

Shielding Gas

Ar, Ar + He

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.8lbs)	5kg (11lbs)
1.0 (0.040)	✓	
1.2 (0.045)	✓	
1.4 (0.052)	✓	
1.6 (1/16)	✓	
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Ni	Ti	Cu	Fe
0.01	0.01	0.85	0.006	0.001	10.6	0.27	Rem	1.0

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)
-	380 (55,000)	36.0		

Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC+	
Ar, Ar + He	160	28
	2.4mm (3/32 in) DC-	
Ar	110	12