

CROMOTEN 9M-15

AWS A/SFA 5.5 E9015-B91

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo91 B 42 H5

KEY FEATURES:

- Basic coated low hydrogen electrode
- Nb and V modified 9Cr-1Mo weld deposit
- Good impact toughness at subzero temperatures
- Excellent strength and creep resistance at high temperature under prolong holding
- All positional capability
- Radiographic quality weld deposit

APPROVALS: - IBR/CE

TYPICAL APPLICATIONS:

- Suitable for welding similar composition creep resistant steels such as P91, T91 and F91
- Welding of material 1.4903 and similar steel Grades
- Application in Petrochemical plants, Power plants, Boilers, Oil refineries

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo	V	Cu	Al	Nb	N
0.1	0.6	0.15	8.7	1.0	0.2	0.01	0.001	0.06	0.03


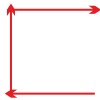
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J
					at +27°C
Typical	PWHT 740°C for 2hrs	670	580	22	30
Specification		620 min	530 min	17 min	40 min

H Diffusible H2 Content: <5 ml/100 gm

Special Tests: Creep Rupture Test at 600°C (100 MPa Stress for min. 1000 hrs.)

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 50-80 90-130 130-170 180-240	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons 5 kg each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 90S-B9	Tigfil-90S-B9	Automig FC 91T-1 B91	Automelt B20 Plus	Automelt B91