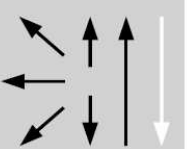


Classifications									
EN ISO 3580-A	AWS A5.5	AWS A5.5M							
E CrMo9 1 B 4 2 H5	E9015-B91H4R	E6215-B91H4R							
Characteristics and typical fields of application									
<p>The basic coated CrMoVNb electrode is specially designed for welding of creep resistant tempered martensitic 9 % Cr steels used for turbine and boiler fabrication in thermal power plants as well as in the chemical industry.</p> <p>Generally for vertical up welding with very good welding characteristics.</p> <p>The chemical composition is optimized in order to provide a high creep resistant and ductile weld metal and is characterized by low hydrogen content and low level of trace elements. This electrode is core wire alloyed thus a very homogeneous alloy dispersal is provided.</p>									
Base materials									
1.4903 – X 10 CrMoVNb 91, ASTM A199 Gr. T91; A213/213M Gr. T91; A355 Gr. P91 (T91)									
Typical analysis of all-weld metal									
	C	Si	Mn	Cr	Mo	Ni	V	Nb	N
wt-%	0.09	0.2	0.6	9.0	1.1	0.8	0.2	0.05	0.04
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J					
	MPa	MPa	%	+20 °C					
sr (760 °C / 2 h)	550	680	17	47					
sr (760 °C / 4 h)	530	620	17	47					
Creep rupture properties: According to base metal P91									
Operating data									
	Polarity:	Electrode identification:	ø mm	L mm	Amps A				
	DC (+)	Chromo 9V/9015-B91/E CrMo91 B	2.5	250	70 – 100				
			3.2	350	100 – 145				
			4.0	350	140 – 190				
			5.0	450	160 – 240				
Welding instruction									
Materials	Preheating	Postweld heat treatment							
200 – 250 °C / 200 – 300 °C	≤ 100 °C	760 °C / 2 h							
Re-drying: 300 – 350 °C / 2 h. Not necessary straight from the tin.									
Approvals									
TÜV (06173), CE									