

CROMOTEN 9M

AWS A/SFA 5.5 **E9018-B91**

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo9L B 32 H5

KEY FEATURES:

- Basic coated electrode
- 9Cr-1Mo-V-Nb type weld deposit
- Excellent strength and creep resistance at high temperature upto 600°C
- Addition of V and Nb increases the resistance to strain, corrosion & oxidation
- Radiographic quality weld deposit
- Positional welding capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Suitable for welding of Cr-Mo-V-Nb steels such as P91, T91 and F91
- Suitable for material 1.4903 and similar steel Grades
- For Turbine rotors, Thermoelectric power plants, Petrochemical plants

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


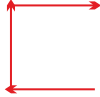
C	Mn	Si	Cr	Mo	V	Cu	Al	Nb	N
0.1	0.6	0.2	9	1.1	0.25	0.005	0.001	0.05	0.04

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at +27°C, J
Typical	PWHT: 740°C for 2 hr.	675	590	20	30
Specification		620 min	530 min	17 min	40 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
3.15 x 350	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 20 kg box containing 4 cartons 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