



CEWELD E 9015-B9 (P92)

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P92									
APPLICATIONS	CEWELD® E 9015-B9 (P92) is a basic coated electrode for modified 9Cr1Mo steels. The weld metal of type 9Cr-1Mo-NVWNb is characterised by a martensitic microstructure and is suitable for tempered applications. Applications include joint welding of similar heat resistant steels and cast steels in turbine and power plant construction and in the chemical industry.									
PROPERTIES	CEWELD® E 9015-B9 (P92) is designed for welding equivalent T/P92 CrMo steels modified with 1.6% tungsten to achieve the creep properties of the base metal. Our electrode is intended for use in structures requiring high resistance at elevated temperatures.									
CLASSIFICATION	AWS	A 5.5: E 9015-B92								
	EN ISO	3580-A: E Z CrMoWVNb9 0,5 2 B 4 2 H5								
	W.Nr.	1.4901								
	F-nr	4								
	FM	4								
SUITABLE FOR	9%Cr,1.7%,W0.5%,Mo, P92, 1.4901, 1.4922 X10CrWMoVNb 9 2, X20CrMoV12-1, ASTM: A182 grade F92, A213 grade T92, A335 grade P92, A387 grade 92, A335 grade T92 NF 616									
APPROVALS	CE									
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	V	Nb	N	W
	0.1	0.2	0.6	8.5	0.5	0.5	0.2	0.05	0.04	1.7
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
						RT				
	760°C±15°C 2h		600	750	18	50			HRc	
REDRYING	400°C / 1 hr									
GAS ACC. EN ISO 14175										