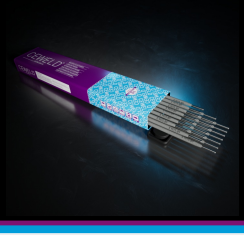

CEWELD E 9015-B9

certilas® THE FILLER METAL SPECIALIST

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P91 and T/P92
TOEPASSINGEN	Headers, main steam piping and turbine casings, in fossil fuelled power generating plants. Oil refineries and coal liquefaction and gasification plants. Preheat and Interpas temperature 200°C - 300°C.
EIGENSCHAPPEN	9015-B9 is designed to weld equivalent 'type T91' T92 CrMo steels modified with small additions of vanadium and tungsten to give improved long term creep properties. These consumables are specifically intended for high integrity structural service at elevated temperature so the minor alloy additions responsible for its creep strength are kept above the minimum considered necessary to ensure satisfactory performance. In this case, weldments will be weakest in the softened (intercritical) HAZ region of parent material, as indicated by so-called 'type IV' failure in transverse weld creep tests.

CLASSIFICATIE

AWS	A 5.5: E9015-B91
EN ISO	3580-A: E CrMo91 B42 H5
F-nr	4
FM	4

GESCHIKT VOOR

P91: 9%Cr-1% Mo ISO 15608: ~5,4 C ≤ 0,35 %, 7,0 % ≤ Cr < 10,0 % und 0,7 < Mo ≤ 1,2 %
1.7386, 1.7688, 1.7389, 1.4903, 1.4955
X12CrMo 9 1, GX12CrMo 10 1, X11CrMo9-1, X7CrMo9-1, X10CrMoVNb9-1, GX12CrMoVNbN9-1
ASTM: Grade 91, T91, P91, F91, FP91, A182/A336 grade F91, A213 grade T91, A217 grade C12A, A234 grade WP91, A387 grade 91, A335 grade P91
STPA28, STBA28

GOEDKEURINGEN

CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	N
0.1	0.3	0.8	0.008	0.008	9	0.65	0.99	0.2	0.05	0.05

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
760°C±15°C 2h	560	750	18	60	HRc

HERDROGEN

300°C / 2 hr

GAS ACC. EN ISO 14175