



CEWELD E 9015-B9

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.5: E9015-B91</td> </tr> <tr> <td>EN ISO</td> <td>3580-A: E CrMo91 B42 H5</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.5: E9015-B91	EN ISO	3580-A: E CrMo91 B42 H5	F-nr	4	FM	4
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GESCHIKT VOOR	9%Cr, 1%Mo, VNb 1.7389, 1.7386, 1.4922, 1.4935, 1.4904, 1.4903, 1.4955, X11CrMo9-1, X12CrMo9.1, X20CrMoV10-1, X10CrMoVNb9-1, GX12CrMoVNbN9-1 ASTM Grade 91, T91, P91, F91, FP91, WP91, C12A 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)	R _m (MPa)	A ₅ (%)	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