

BASOWELD 91CrMo

Electrodes MMA [SMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3580-A : E CrMo91 B 42 H5 AWS A-5.5 : E 9015-B9	UDT	Power generation industry

- Basic low hydrogen electrode with the addition of Cr, Mo, V and Nb.
- For welding creep-resistant P 91(T91) steels up to 620°C.

Base material

W.Nr	DIN	UNS ASME ASTM
1.4903	X10CrMoVNb9-1	K90901, A182 F91, A213 T91
1.7386	X12CrMo91	K90941
1.4935	X20CrMoWV12-1	S42200
1.7389	GX12CrMo10-1	
1.4922	X20CrMoV12-1, X20CrMoV11-1	
1.4904	X10CrMoVNb9-1	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	Nb	N
0,10	0,35	0,80	9,00	0,70	1,00	0,20	0,05	0,04

Typical mechanical properties

Yield strength Re [N/mm²]	415
Tensile strength Rm [N/mm²]	585
Elongation A5 [%]	>17
Impact energy Kv [J]	>47] (20°C) /
Coating type	basic
Welding current	
Welding positions	
Redrying	350° / 1h or 300°C / 2 h
Additional description	After heat treatment, tempered martensite structure with alloy carbides. Pre-heating and interstitch temperature around 200-300[°C]. To ensure full transformation of martensite, welds should be cooled down to 100[°C] before heat treatment.

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	70-110	1,5	9,0
3,2	350 /	95-150	1,5	9,0

4,0

350 /

130-180

1,5

9,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl