

## MIGWELD 91CrMo

MIG/MAG Wires [GMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 21952-A : G CrMo91 AWS A-5.28 : ER 90 S-B9		Power generation industry

- Solid welding wire with the addition of Cr, Mo, V and Nb for MIG/MAG welding.
- Used for welding P91 steels working under pressure.
- Working temperature of the weld metal up to 600°C.

### Application

Steam boilers, pipelines, fittings

### Base material

#### ASTM A 335:

P91 (T91)

### Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	Nb
0,10	0,25	0,50	9,20	0,41	1,00	0,20	0,05

### Typical mechanical properties

Yield strength Re [N/mm <sup>2</sup> ]	≥520
Tensile strength Rm [N/mm <sup>2</sup> ]	≥620
Elongation A5 [%]	≥16
Impact energy Kv [J]	>47J (20°C) /
Heat treatment	Annealing: 720°C/30 min, furnace cooling to 300°C, then in air

### Welding parameters and packing

Ø	Weight of packet [kg]
0,8	15,0
1,0	15,0
1,2	15,0

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