









CEWELD E 9015-B9 (P92)

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P92									
APPLICATIONS	Headers, main steam piping and turbine casings, in fossil fuelled power generating plants. Oil refineries and coal liquefaction and gasification plants. Preheat and Interpass temperature 200°C - 300°C.									
PROPERTIES	9015-B9 (P92) is designed to weld equivalent 'type T/P92 CrMo steels modified with 1,6% Tungsten to match the base metal 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.									
CLASSIFICATION	AWS	A 5.5: E 9015-B92								
	EN ISO	3580-A: E Z CrMoWVNb9 0,5 2 B 4 2 H5								
	F-nr	4								
	FM	4								
	W.Nr.	1.4901								
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	No Approvals Found									
WELDING POSITIONS	<div>     </div>									
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
ALL WELD MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT				
	760°C±15°C /2h		600	750	18	50				
REDRYING TEMPERATURE	400°C / 1 hr									
GAS ACCORDING EN 14175										