









CEWELD E 9018-B9

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P91 and T/P92										
APPLICATIONS	Headers, main steam piping and turbine casings, in fossil fueled power generating plants. Oil refineries and coal liquefaction and gasification plants. Preheat and Interpass temperature 200°C - 300°C.										
PROPERTIES	CEWELD E 9018-B9 is designed to weld equivalent 'type T91' CrMo steels modified with small additions of niobium and Vanadium 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.										
CLASSIFICATION	AWS	A 5.5: E 9018-B91									
	EN ISO	3580-A: E CrMo91 B42 H5									
	F-nr	4									
	FM	3									
SUITABLE FOR	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										
APPROVALS	CE										
WELDING POSITIONS	     										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	N
	0.09	0.3	0.9	0.01	0.01	9	0.6	0.9	0.2	0.06	0.04
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V						
	As Welded /	550	700	21	RT						
					55						
REDRYING TEMPERATURE	400°C / 1 hr										
GAS ACCORDING EN 14175											



CEWELD E 9018-B9

E 9018-B9 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663400505

E 9018-B9 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663400536

E 9018-B9 4,0 X 450MM

Type	KG/unit	EANCode
Can	3,3	8720663400567