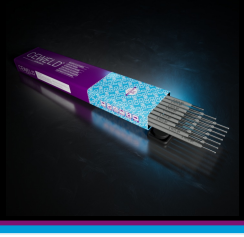

CEWELD E 9015-B9

certilas® THE FILLER METAL SPECIALIST

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 fuelled power generating plants. Oil refineries and coal liquefaction and gasification plants. Preheat and Interpas temperature 200°C - 300°C.
PROPERTIES	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.

CLASSIFICATION

AWS	A 5.5: E 9015-B9
EN ISO	3580-A: E CrMo91 B42 H5
F-nr	4
FM	4

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
0.1	0.2	0.6	0.008	0.008	9	0.6	0.9	0.2	0.05	0.05

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
760°C±15°C /2h	560	750	18	41

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175