

T-90SB9

For 9%Cr-1%Mo-V heat-resistant steel

Classifications

EN ISO 21952-A:2007	: CrMo91
EN ISO 21952-B:2007	: 9C1MV
AWS A5.28-05	: ER90S-B9

Description

- For butt and fillet welding of power plant, heat exchanger and oil refineries such as 9%Cr-1%Mo-V heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- Preheat at 150°... to 300°... and post weld heat treatment at 740°C to 780°C is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Cr	Mo
0.10	0.23	0.75	0.005	0.002	9.10	0.94

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 20°C	Remarks
AWS A5.28	min. 410	min. 620	min. 16		PWHT, Ar
EN ISO 21952-A	min. 415	min. 585	min. 17	≥ 47	PWHT, Ar
EN ISO 21952-B	min. 410	min. 620	min. 15	-	PWHT, Ar
Example	673	745	20	334	PWHT, Ar

* PWHT : 760°Cx2Hr

Operating data

Diameter (mm)	2.4~3.2
Current (Amp.)	200 ~ 300

Polarity and Shielding gas

- DCEN (DC-)
- Ar : 100%Ar (15~25l/min)