

**Classifications**

EN ISO 3580-A:2008	: E CrMo91 B 42 H5
EN ISO 3580-B:2008	: E 62 15-9C1MV H5
AWS A5.5-15	: E9015-B91 H4R

**Description**

- Covering is low hydrogen type for welding of 9%Cr-1%Mo-Nb-V steel used in oil refining and chemical industries, heat treated high tensile strength steel for P91
- Preheat at 250~350°C and postheat treat at 720~770°C
- Excellent crack resistance because of low hydrogen contents.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V	Nb
0.09	0.27	0.62	0.01	0.01	0.28	8.92	1.08	0.22	0.08

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 530	min. 620	min. 17			
EN ISO 3580-A	min. 415	min. 585	min. 17	≥ 47		
Example	680	760	21	60	40	PWHT

\* PWHT : 760°Cx1Hr.

**Sizes available and recommended currents (DC +)**

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	50-90 50-80	75-115 70-110	120-160 90-130	160-210 -	210-260 -