

## CARBO CrMo 91 B

International standards		DIN EN ISO 3580-A			E CrMo91 B 42 H5							
		AWS A	AWS A 5.5 E9015-B9									
Approvals												
Typical applications and characteristics		Basic coated electrode with low hydrogen content for welding high tem- perature martensitic, creep resistant 9-12 % chromium steels such as P91 and T91 in all positions except vertical down. The deposits have good toughness properties even under long term stresses and high creep rupture strength. Preheating and interpass temperature 250-350°C, after welding annealing 750°C/> 2h.										
Operating temperature		Room temperature up to + 650 °C										
Base materials		1.4904 X10CrMoVNb9-1 1.7386 X12CrMo9-1 1.7389 GX12CrMo10-1										
Mechanical properties of all-weld metal ( typical values)		Tensile strength			eld strengt	Elongation		Impact energy				
		R <sub>m</sub> N/mm <sup>2</sup>		R <sub>eL</sub> N/mm²			A <sub>5</sub> %		ISO–V J + 20°C			
		760		650			> 17		> 70			
			<b>.</b>									
weig metal analysis		C	Si	Mn	Cr	Mo	D Ni	1	/ N	b	N	
(typical, wt %)		0,1	0,35	0,8	9,0	1,0	) 0,7	0	,2 0,0	)5	0,04	
Current		=+										
Welding positions		PA, PB, PC, PD, PE, PF,										
Rebaking		1 h, 35	0 °C + / - 1	0 °C	c ( if necessary)							
Dia./Length	Amperag	je (A)	Pcs./ pack	cet   F	Pcs./ carto	n k	(g / 1000	kg /	kg / packet		/ carton	
$25 \times 350$	70 - 1	10	234		935		21.4		5.0		20.0	

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3.2 x 350

4.0 x 350

95 - 150

130 - 190

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.

552

364

36.2

54.9

5.0

5.0

20.0

20.0

138

91