

Stick electrode for 9%Cr-1%Mo-Nb-V steel

- Features:**
- Applied for ASTM A387 Gr.91 and equivalents
 - Excellent creep rupture strength

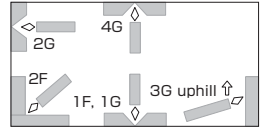
Classification: AWS A5.5 E9015-B9

Redrying Conditions: 325~375°Cx1h

Identification color: 1st Yellow, 2nd Brown

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 115H, 430L
5.0	400	5	20	85	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.10	0.08~0.13
Si	0.26	0.30
Mn	0.89	1.20
P	0.01	0.01
S	<0.01	0.01
Ni	0.45	0.80
Cr	9.1	8.0~10.5
Mo	1.04	0.85~1.20
Nb	0.04	0.02~0.10
V	0.22	0.15~0.30
Cu	0.02	0.25
Al	<0.01	0.04
N	0.03	0.02~0.07
Mn+Ni	1.34	1.50

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	75~115	70~110
4.0	120~160	90~140
5.0	160~220	-

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	651	531min.
TS (MPa)	768	621min.
El on 4d (%)	22	17min.
IV 20°C (J)	74	-
PWHT (°C×h)	760x2	760±15x2