

CROMOTEN 9M

CLASSIFICATIONS

AWS A/SFA 5.5 E9018-B9

IDENTIFICATION: Name Printed

CHARACTERISTICS

Basic coated, extra low hydrogen electrode for welding creep resistant steel/pipes type 9 Cr-1Mo-V-Nb type P91/T91. The electrode is suitable for all position welding and deposits weld metal of Radiographic quality.

TYPICAL APPLICATIONS

For welding high-temperature Cr Mo V Nb steel with 9% Cr for tubes and pipes - A STM A 387-Gr.91.

X 10 Cr Mo V Nb 91 (1.4903)

A213 - T91

A335 - P91

CURRENT CONDITIONS: AC (70V), DC (+)

5.0	4.0	3.2	2.5
190-250	140-180	100-140	60- 90

WELDING POSITIONS

F, H, V -up, OH

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition)

WELD METAL CHEMISTRY (%)

C - 0.08-0.12	S - 0.01 max.	V - 0.15-0.30
Mn - 0.60-1.0	Ni - 0.80 max.	Cu - 0.35 max.
Si - 0.30 max.	Cr - 8.0-10.5	Al - 0.02-0.10
P - 0.01 max.	Mo - 0.90-1.20	Nb - 0.02-0.07

Diffusible H₂ content <5 ml / 100gm of weld metal

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	450	450	350
Pcs per carton, Nos	70	110	211
Cartons / box	4	4	4
Pcs per box, Nos	280	440	844
Approx. Wt. of 1000 pcs,kg	71	45	24

MECHANICAL PROPERTIES-ALL-WELD (PWHT 760°C/ 2hr)

Condition	UTS MPa	YS MPa	% Elong. (L = 4Xd)	CVN Impacts, J 20°C
PWHT	620-720	530-625	17-22	47



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