

GETIG 90SB9



SOLID WIRE FOR CREEP RESISTING STEELS

IDENTIFICATION :ER 90S-B9

CLASSIFICATION : AWS/SFA 5.28: ER 90S-B9

DESCRIPTION :

A non-coppered filler wire of high purity to match creep resisting steels of type 9CrMo modified with controlled additions of niobium, vanadium & nitrogen. Deposited weld metal meets X-ray quality.

TYPICAL USES

These materials are used in components such as, headers, main steam piping and turbine rotors in power generating plant. Applications are also anticipated in oil refinery & petrochemical plant. Service temperature is normally 500-600°C, higher temperatures upto 650°C may be limited by parent HAZ properties.

Materials to be welded:

ASTM-ASME : A213 T91(tube),A387 Grade 91(plate), A335 P91(pipe), A182, A336 F91(forgings).

DIN : X10CrMoVNb9 1 1.4903

PREHEAT AND INTERPASS

TEMPERATURE 150-260 °C

SHIELDING GAS : Argon/ 5% O₂

COMPOSITION OF THE WIRE (RANGE) %:

C	Mn	Si	S	P	Cr	Mo	Cu	Nb	V	N
0.07-0.13	1.25 max	0.15-0.30	0.010 max	0.010 max	8.0-9.5	0.8-1.10	0.20 max	0.02-0.10	0.15-0.25	0.03-0.07

MECHANICAL PROPERTIES (RANGE) (PWHT 745 ± 15°C/1 hr.)

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)
620 min	410 min	16 min

PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER BOX,KG
1.6	1000	5Kg
2.4/2.50	1000	5Kg
3.15/3.2	1000	5Kg