



CEWELD E 9015-B9

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P91										
APPLICATIONS	CEWELD® E 9015-B9 is a basic coated electrode for modified 9Cr-1Mo steels. The weld metal of type 9Cr-1Mo-VNb is characterised by a martensitic structure and is suitable for tempered applications. Applications include joint welding of similar heat resistant steels and cast steels in turbine and power plant construction and in the chemical industry.										
PROPERTIES	The weld metal of CEWELD® E 9015-B9 has a very low hydrogen content and is suitable for application temperatures up to max. 650°C in the long term range. Preheat and interpass 250 - 350°C, then a tempering of 750°C / >2h. It can be short arc welded in all positions, vertical down.										
CLASSIFICATION	AWS	A 5.5: E9015-B91									
	EN ISO	3580-A: E CrMo91 B42 H5									
	F-nr	4									
	FM	4									
SUITABLE FOR	P91: 9%Cr-1% Mo ISO 15608: ~5,4 C ≤ 0,35 %, 7,0 % ≤ Cr < 10,0 % und 0,7 < Mo ≤ 1,2 % 1.7386, 1.7688, 1.7389, 1.4903, 1.4955 X12CrMo 9 1, GX12CrMo 10 1, X11CrMo9-1, X7CrMo9-1, X10CrMoVNb9-1, GX12CrMoVNbN9-1 ASTM: Grade 91, T91, P91, F91, FP91, A182/A336 grade F91, A213 grade T91, A217 grade C12A, A234 grade WP91, A387 grade 91, A335 grade P91 STPA28, STBA28										
APPROVALS	CE										
WELDING POSITIONS	PA PB PC PF PD PE										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	N
	0.1	0.3	0.8	0.008	0.008	9	0.65	0.99	0.2	0.05	0.05
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness	
	760°C±15°C 2h		560	750	18	RT				HRc	
REDRYING	300°C / 2 hr										
GAS ACC. EN ISO 14175											