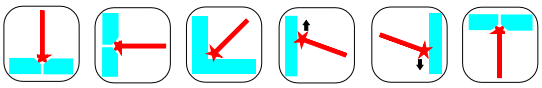
SGCrMo91

SFA-AWS A5.28 ER90S-B9
EN ISO 21952-A- G CrMo9 1

DESCRIPTION

The addition of V and Nb increases the resistance to strain, corrosion and heat oxidation. Excellent resistance to creep and hydrogen. Suitable for thermoelectrical power plants, turbine rotors, petrochemical plants.

WELDING POSITIONS	CURRENT	GAS
	DC+	Ar/ Co2 (M21, M20)

BASE MATERIALS

Construction steel, pressure steel

X10CrMoVNb9-1; X12CrMo9-1; A335: P91, A213: T91, A387: 91, A182: F91, X 20CrMoV12-1

MECHANICAL PROPERTIES

Rm (Mpa)	***Rp 0,2 (Mpa)***	***A5 (%)***	***KV(j)***
780	690	21	150 J (+20° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	P	S	Cu	Cr	Ni	Mo	Al	V	N	Nb
0,09	0,30	0,50	<0,01	<0,01	<0,25	9,1	0,50	0,90	<0,04	0,20	0,05	0,07

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	5/16	5/16	5/16	16
Wire feeding (m/min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	90-160	150-250	220-320	250-400
Volt (V)	18-22	22-28	26-32	28-36

EQUIVALENT FILLER METALS

TIG	Meltolit SGCrMo91
MMA	Meltolit CrMo91 E

Pre heating temperature 205-260°C, Interpass temperature 205-260°C, post welding heat treatment 745+/-15°C