

Meltolit

SGCrMo91 Tig

AWS A 5.28: ER90S-B9 ISO 21952-A: W CrMo9 1

DESCRIPTION

For CrMo-alloyed high temperature steels. Alloyed with Vanadium(V) and Niobium(Nb) for increased 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

DC -

GAS

I1

BASE MATERIALS

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

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
780	690	21	150 J (+20° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	Mo	Cr	Cu	Ni
0,09	0,3	0,5	0,9	9,1	<0,2	<0,50
Al	V	N	Nb			
<0,04	0,2	0,05	0,07			

PACKAGING

Dimension(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box(kg)	5	5	5	5

EQUIVALENT FILLER METALS

MAG	Meltolit SGCrMo91 Mag
MMA	Meltolit CrMo91 E

Pre heating is recommended to 205-320°C. Interpass temperature 205-320°C. Post welding heat treatment 750°C for one hour and slow cooling.