

## ❖ Product Description

- |  |                               |
|--|-------------------------------|
| I. Copper coated low alloy solid wire              | IV. Improved creep properties |
| II. Uniform copper coating                         | V. Radiographic weld quality  |
| III. The weld deposit in typical 9Cr-1Mo-V-Nb type |                               |

## ❖ Range of Application

- |   |   |
|---|---|
| I. Welding of Cr-Mo-Vb-Nb steels such as P91, T91 and F91               | III. Can be used for heavy wall components such as headers, main steam piping and turbine rotors in power generating plants |
| II. Suitable for materials 1.4909, SA 387 Gr.91, SA 213 T91, SA 335 P91 |   |

## ❖ Classification

- AWS/SFA 5.28 ER90S- B9

## ❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Mo	Cr	Cu	Other Elements
ER90S- B9	Min	0.07	-	-	0.15	-	0.85	8.00	-	-
	Max	0.13	1.2	0.010	0.50	0.010	1.20	10.50	0.20	0.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, MPa (Min0	% Elongation min	Charphy "v" Notch Impact @ 0°C
PWHT	-	-	-	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00.
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEN; 8-15lit/min

## ❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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