

Cr and Mo-alloyed electrode for heat resistant steels.

STARBLAZE PRIME 9018-B9

Classification

AWS A 5.5: E9018 B-91

EN ISO 3580-A: E CrMo9L B 4 2 H5

Description and applications

Basic coated low hydrogen electrode for welding high temperature creep resistant steels type 9 Cr-1Mo-V-Nb-N with operating temperatures up to +620°C. Best suitable for welding of P91, T91 and F91 type of steels. Excellent weldability, self-peeling slag, finely rippled weld bead. Welds are of radiographic quality. Used for turbine rotors, petrochemicals plants, thermoelectric power plants.....etc

Base materials

T91(ASTM A213), F91(ASTM A182), P91(ASTM A335), grade 91 (ASTM A 387), X10CrMoVNb9-1

Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Mo	Ni	S	P	V	Nb	N
0.10	0.25	0.60	9.00	1.00	0.60	≤0.010	≤0.010	0.20	0.050	0.04

Diffusible hydrogen (Per 100gm weld metal):	< 4 ml.
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All weld metal mechanical properties (typical)

Heat Treatment	Yield strength R _p (N/mm ²)	Tensile strength R _m (N/mm ²)	Elongation A5 (%)	Impact Energy ISO-V(J)+20°C
PWHT 760°C X 2h	≥ 530	≥ 650	≥ 18	≥ 47

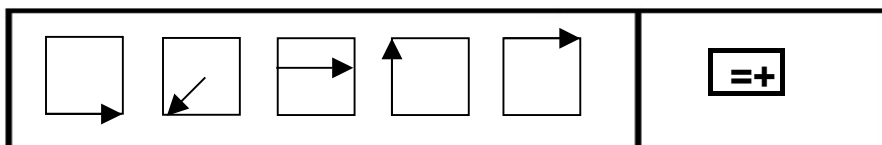
Amperes (A)

2.50mm	3.15mm	4.0mm	5.0mm
60- 90	90- 130	140- 180	180- 240

Welding instruction

Storage and re-drying: Keep dry and avoid condensation. Redry electrodes at 300 – 350°C for 1 hour.

Welding positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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