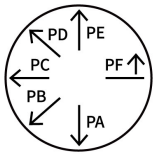


S-9015.B9

Classification

AWS A5.5/ASME SFA-5.5 E9015-B91
JIS Z 3223 E6215-9C1MV
EN ISO 3580-A E CrMo91 B 4 2 H5

Welding Positions



Features

- Good creep resistance at high temperature
- Maximum service temperature at 650°C (1202°F)
- Low-Hydrogen electrode (HDM ≤5ml/100g)
- Good performance with DCEP

Polarity

DC ±

Application Areas

- Low alloy steel (9%Cr-1%Mo)
- Pressure vessels
- Power plants

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Nb	Al	V	N
0.10	0.27	0.85	0.009	0.006	0.03	0.29	8.9	0.99	0.04	0.01	0.20	0.03

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
760°C*2hr	603(87)	747(108)	24	RT	55(41)
760°C*4hr	611(89)	732(106)	24	RT	60(44)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	350 (14)	55~90	50~80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2 (1/8)	400 (14)	90~130	80~120	
4.0 (5/32)	400 (16)	130~190	120~180	
5.0 (3/16)	450 (18)	190~240	-	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux