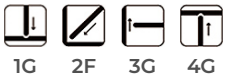
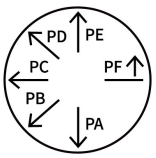
S-9016.B9

Classification

AWS A5.5/ASME SFA-5.5 E9016-B91
JIS Z 3223 E6216-9C1MV
EN ISO 3580-A E CrMo91 B 3 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)

Polarity

AC, DC ±

Application Areas

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

Redrying Conditions

350~400°C (662~752°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
0.09	0.23	0.80	0.009	0.006	0.05	0.27	8.2	0.88	0.02	0.01	0.19	0.04

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	612(89)	727(105)	28	RT	71(52)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	350 (14)	100~140	90~130	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2 (1/8)	400 (14)	120~160	110~150	
4.0 (5/32)	400 (16)	150~190	140~180	
5.0 (3/16)	450 (18)	180~240	-	