

CARBOROD CrMo91 is an uncoated WCrMo91/ER90S-B9 type solid TIG welding rod for welding creep resisting steels of the type 9Cr 1Mo V Nb N. Suitable for use with Ar shielding gas.

CARBOROD CrMo91 is especially designed for the ASTM steels T91/P91. This product is suitable for applications in long-term service at temperatures up to 650°C.

Improved creep strength is obtained by the addition of nitrogen, niobium and vanadium.

Classification

EN ISO	21952-A: W CrMo91
AWS	A5.28: ER 90S-B9

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Nb	V
0.10	0.5	0.30	9.1	0.65	1.0	0.06	0.22

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
760 °C x 2h	≥ 620	≥ 720	≥ 19	≥ 50

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

ASTM: A 213 T91; A 335 P91; A 387 Gr 91; A 182 F91; A336 F91

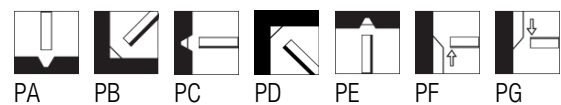
EN 10028-2: X10CrMoVNB9-1; 1.4903

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)
1.6	TUB	5
2.0	TUB	5
2.4	TUB	5