



CEWELD E 9015-B9 (P92)

TYPE	Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P92										
APPLICATIONS	CEWELD® E 9015-B9 (P92) is a basic stick electrode for modified 9Cr1Mo steels. The weld metal of type 9Cr-1Mo-NVWNb is characterized by a martensitic microstructure and is suitable for applications in the tempered condition. The range of applications includes joint welding of similar heat-resistant steels and cast steel in turbine and power plant construction as well as in the chemical industry.										
PROPERTIES	CEWELD® E 9015-B9 (P92) is designed for welding equivalent CrMo steels of type T/P92 modified with 1.6% tungsten to achieve the creep properties of the base metal. Our electrode is intended for use in constructions with high resistance at elevated temperatures.										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.5: E 9015-B92</td> </tr> <tr> <td>EN ISO</td> <td>3580-A: E Z CrMoWVNb9 0,5 2 B 4 2 H5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4901</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.5: E 9015-B92	EN ISO	3580-A: E Z CrMoWVNb9 0,5 2 B 4 2 H5	W.Nr.	1.4901	F-nr	4	FM	4
AWS	A 5.5: E 9015-B92										
EN ISO	3580-A: E Z CrMoWVNb9 0,5 2 B 4 2 H5										
W.Nr.	1.4901										
F-nr	4										
FM	4										
SUITABLE FOR	9%Cr, 1.7%W, 0.5%Mo, P92, 1.4901, 1.4922 X10CrWMoVNb 9 2, X20CrMoV12-1, ASTM: A182 grade F92, A213 grade T92, A335 grade P92, A387 grade 92, A335 grade T92 NF 616										

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	V	Nb	N	W
0.1	0.2	0.6	8.5	0.5	0.5	0.2	0.05	0.04	1.7

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
760°C ± 15°C 2h	600	750	18	50		HRc

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175