

GETIG 90S-B9

SOLID WIRE FOR CREEP RESISTING STEELS

IDENTIFICATION

Getig 90SB9, ER 90SB9

CLASSIFICATION

AWS/SFA 5.28: ER 90S-B9

DESCRIPTION

A non-coppered filler wire of high purity to match creep resisting steels of type 9 CrMo modified with controlled additions of niobium, vanadium & nitrogen. Deposited weld metal meets X-ray quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	Cu	Ni	V	N
0.07 - 0.13	1.2 max	0.15 - 0.50	0.01 max	0.01 max	8.0 - 10.5	0.85 - 1.20	0.2 max	0.8 max	0.15 - 0.30	0.03 - 0.07

MECHANICAL PROPERTIES (RANGE) (PWHT 745 ± 150C/1 HR.)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)
620 min	410 min	16 min

TYPICAL APPLICATIONS

- These materials are used in components such as, headers, main steam piping and turbine rotors in power generating plant.
- Applications are also anticipated in oil refinery & petrochemical plant.
- Service temperature is normally 500 - 600°C, higher temperatures upto 650°C may be limited by parent HAZ properties.

MATERIALS TO BE WELDED

ASTM-ASME : A213 T91 (tube), A387 Grade 91 (plate), A335 P91 (pipe), A182, A336 F91 (forgings).

DIN : X10CrMoVNb9 1 1.4903

PREHEAT AND INTERPASS TEMPERATURE : 150 - 260°C

SHIELDING GAS : Argon / 5% O₂

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20