

GRIDUCT 95B92

IDENTIFICATION

Griduct 95B 92, EE 9015-B92

CLASSIFICATION

AWS / SFA 5.5: E 9015-B92

DESCRIPTION

Non-synthetic Hydrogen controlled, heavy coated basic type electrode depositing 9Cr-0.2Mo-16W-0.2V- Nb alloyed weld metal.

Deposited weld metal has improved creep strength toughness and fatigue life and oxidation and corrosion resistance at elevated temperature upto 620°C.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	V	Nb	N	Al	Cu	W	Co
0.07 - 0.14	0.4 - 1.20	0.2 - 0.60	0.01 max	0.012 max	8.0 - 9.9	0.20 - 0.50	0.15 - 0.25	0.02 - 0.07	0.03 - 0.07	0.02 max	0.04 max	1.30 - 2.0	0.50 - 1.80

MECHANICAL PROPERTIES PWHT : 760°C. for 2 hours.

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
630 - 800	17 - 24	20°C	40 min

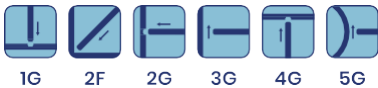
TYPICAL APPLICATIONS

For welding creep resistance steels type T92 / P92 and equivalents.

REDRYING TEMPERATURE FOR ELECTRODES : 350°C / 2 hrs

MICROSTRUCTURE : In PWHT condition, the microstructure consists of tempered martensite.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	80 - 130	5 x 4 = 20	110 x 4 = 440
4	450	130 - 170	5 x 4 = 20	70 x 4 = 280
5	450	160 - 220	5 x 4 = 20	45 x 4 = 180