

EF-200HCxKD-B9

For 9%Cr-1%Mo-Nb-V heat resistant steel

Classifications

• Sub-arc flux

EN ISO 14174 - 2012 : SA FB 2 55 DC

• Flux/ Wire-combination

EN ISO 24598 : S CrMo91 FB
 AWS A5.23-2015 : F10PZ-EB91-B91

• SAW solid wire

EN ISO 24598-A : S CrMo91
 EN ISO 24598-B : SU 9C1MV
 AWS A5.23 - 2015 : EB91

Description

- It is designed for welding of 9%Cr-1%Mo-Nb-V(T91/P91) steel used in oil refining industries, high pressure vessels., etc.
- For joining and surfacing applications of creep resistant CrMo steels such as T91/P92.
- It has easy slag removal and good weld soundness.
- Redry the flux at 250~350°C for 60 minutes before use.
- Add new flux periodically when continuously reusing the flux.
- Excessive flux height may bring out poor bead appearance.

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Cr	Mo	Nb	V	Ni
0.10	0.20	0.80	8.10	0.90	0.05	0.18	0.40

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) +20°C	Remarks
AWS A5.23	min. 610	690~830	min. 16		
EN ISO 24598-B	min. 415	min. 585	min. 17		
Example	700	800	20	50	PWHT

* PWHT : Post Weld Heat Treatment (760°Cx2Hr.)