



CEWELD E 9016-B9

TYPE Basic, Cr and Mo-alloyed electrode for heat resistant steels T/P91 and T/P92

APPLICATIONS Headers, main steam piping and turbine casings, in fossil fuelled power generating plants. Oil refineries and coal liquefaction and gasification plants. Preheat and Interpas temperature 200°C - 300°C.

PROPRIÉTÉS CEWELD® E 9016-B9 is designed to weld equivalent 'type T91' T92 CrMo steels modified with small additions of Tungsten and Vanadium to give improved long term creep properties. These consumables are specifically intended for high integrity structural service at elevated temperature so the minor alloy additions responsible for its creep strength are kept above the minimum considered necessary to ensure satisfactory performance. In this case, weldments will be weakest in the softened (intercritical) HAZ region of parent material, as indicated by so-called 'type IV' failure in transverse weld creep tests.

CLASSIFICATION

AWS	A 5.5: E9016-B91
EN ISO	3580-A: E CrMo91
F-nr	4
FM	4

CONVIENT POUR **9%Cr, 1%Mo, VNb**
 1.7389, 1.7386, 1.4922, 1.4935, 1.4904, 1.4903, 1.4955,
 X11CrMo9-1, X12CrMo9.1, X20CrMoV10-1, X10CrMoVNb9-1, GX12CrMoVNbN9-1
 ASTM Grade 91, T91, P91, F91, FP91, WP91, C12A
 STPA28, STBA28

AGRÉMENTS CE

POSITIONS DE SOUDAGE



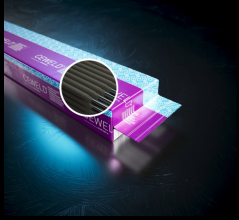



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	V	N
	0.1	0.3	0.9	0.008	0.008	9	0.5	1	0.08	0.2	0.03

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					RT	
		As Welded	550	680	18	60

ETUVAGE 400°C / 1 hr

GAS ACC. EN ISO 14175



CEWELD E 9016-B9

E 9016-B9 3,2 X 350MM

Packaging	KG/unit	EanCode
VAC pack	1,9	8720663401465