

9CRMV MIG

Low Alloy Steel · AWS ER90S-B9

KEY FEATURES

- B9 (P91) alloyed steel: Modified 9CrMo designed to weld equivalent "type 91" 9CrMo steels modified with small additions of niobium, vanadium and nitrogen for improved long term creep resistance
- Specifically designed for high integrity structural service at elevated temperature
- Non-copper coated solid wire with Ni+Mn<1.0%
- Weld metal chemistry is low in impurity elements allowing it to respect the X Factor (<15ppm) and J-factor (<120ppm)

WELDING POSITIONS

All

SHIELDING GAS

5-20% CO₂ /Argon

CONFORMANCES

AWS A5.28: ER90S-B9

BS EN ISO 21952-A: G 9C1MV

TYPICAL APPLICATIONS

- Main Steam Piping
- Oil Refineries
- Coal Liquefaction and Gasification Plants
- Power Generation Plants
- Turbine Castings

DIAMETERS / PACKAGING

Diameter mm (in)	15kg (33lb) Spool
1.0 (0.040)	M9CRMV-10

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.28/A5.28M

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @20°C (68°F)
Requirements - AWS ER90S-B9	415 (60)	620 (90)	17	47 (35) min

DEPOSIT COMPOSITION – s Required per AWS A5.28/A5.28M

	%C	%Mn	%Si	%S	%P	%Cr	%Ni
Requirements - AWS ER90S-B9	0.08-0.13	0.40-0.80	0.15-0.50	0.010 max	0.010 max	8.5-9.5	0.10-0.40
Typical Results ⁽³⁾	0.10	0.50	0.25	0.005	0.008	8.7	0.30
	%Mo	%Nb	%V	%N	%Cu	%Al	
Requirements - AWS ER90S-B9	0.85-1.10	0.03-0.08	0.15-0.25	0.03-0.07	0.10 max	0.04 max	
Typical Results ⁽³⁾	1.0	0.05	0.20	0.05	0.03	<0.01	

TYPICAL OPERATING PROCEDURES

Polarity	Diameter mm (in)	Current (Amps)	Voltage (Volts)
DC+	1.2 (0.047)	280	26

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer ⁽⁴⁾CTWD [Contact Tip to Work Distance]. Subtract 1/4 in [6.4 mm] to calculate Electrical Stickout.

⁽⁵⁾Procedures in these areas are procedures for short circuiting mode using 100% CO₂. When using 75% Argon, 25% CO₂ for short circuit transfer, reduce voltage by 1 to 2 volts.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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