# CROMOCORD 9M

## TOP FEATURES

- Approved for operating temperature up to +625°C
- The Nickel free weld metal improves the tensile strength at high temperature
- Very low diffusible hydrogen (HD<4ml/100g)
- Excellent radiographic examination results
- Offers excellent operability in all position welding except vertical down
- Stable arc with low spatter, easy slag removal and excellent bead profile

## CLASSIFICATION

| | |
|---|---|
| AWS A5.5 | E9018-B91 H4 |
| EN ISO 3580-A | E Z CrMo9 B 4 2 H5 |

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions, except vertical down

## APPROVALS

TÜV

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

| C | Mn | Si | P | S | Cr | Mo | Nb | V | N |
|---|---|---|---|---|---|---|---|---|---|
| 0.09 | 0.95 | 0.25 | 0.01 | ≤0.010 | 9 | 1 | 0.07 | 0.20 | 0.04 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Condition | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) +20°C |
|---|---|---|---|---|---|
| AWS A5.5 | PWHT | ≥530 | ≥620 | ≥17 | - |
| EN ISO 3580-A | PWHT | ≥460 | ≥550 | ≥17 | - |
| Typical values | 760°C x 2h | 550 | 640 | 18 | 60 |

PWHT: Postweld Heat Treatment 725-755°C / min 1h

Preheat and interpass temperature: 205-260°C

- = not specified

## OPERATING CURRENT RANGE

| Diameter x Length (mm) | Current range (A) |
|---|---|
| 3.2 x 350 | 85-130 |
| 4.0 x 450 | 130-160 |

## AVAILABLE SIZES AND PACKAGING INFORMATION

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|---|---|---|---|---|
| 3.2 x 350 | CBOX | 110 | 4.1 | W100258354 |
| 4.0 x 450 | CBOX | 70 | 5.2 | W100258355 |

## 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

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.