CROMO E91

TOP FEATURES

- Excellent tensile strength in creep regime.
- Good impact toughness down to -20°C.
- Low diffusible hydrogen (HD<4ml/100g).

CLASSIFICATION

AWS A5.5	E9015-B91 H4
EN ISO 3580-A	E (CrMo91) B 2 2 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Cr	Ni	Mo	V	N	X-Factor
0.11	0.8	≤0.3	≤0.010	≤0.010	8.5	0.4	0.050	0.2	0.050	<15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	0°C
AWS A5.5	PWHT	≥530	≥620	≥17	not specified	not specified
EN ISO 3580-A	PWHT	≥530	≥620	≥15	≥47	not specified
Typical values	760°C x 2h	610	730	20	85	27

PWHT: Postweld Heat Treatment 745-755°C / min 2h (heating rate in the furnace shell be 85°C/h to 275°C/h)

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-85
3.2 x 350	95-110
4.0 x 350	125-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	CBOX	190	3.9	W100386546
3.2x350	CBOX	119	3.9	W100386547
4.0x350	CBOX	85	4.1	W100386548

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.