

Chromet® 9MV-N

TOP FEATURES

- Designed for corrosion resistance in elevated temperatures up to 600°C
- Moisture resistant coating provides low amounts of weld metal hydrogen levels for a superior weld
- Smooth arc performance in all positions

TYPICAL APPLICATIONS

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

CLASSIFICATION

AWS A5.5 E9015-B91 H4
EN ISO 3580-A E CrMo91 B 3 2 H5

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV

+

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

	C	Mn*	Si	S	P	Cr	Ni**	Mo	Nb	V	N	Cu	Al
Min.	0.08	0.50	not specified	not specified	not specified	8.0	0.40	0.85	0.04	0.15	0.03	not specified	not specified
Max.	0.12	0.80	0.30	0.01	0.01	10.0	0.70	1.20	0.07	0.25	0.07	0.25	0.04
Typical	0.1	0.6	0.25	0.008	0.01	9.0	0.5	1.0	0.05	0.2	0.05	0.05	0.01

*Mn+Ni ≤ 1.2%

**Low Ni and low Mn+Ni variant is available : Chromet 9-B9.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT		min.*	20°C	Typical (760°C / 2h)		650°C
				550°C	600°C	
Tensile strength	(MPa)	620	770	>450	>375	>285
0.2% Proof strength	(MPa)	530	640	>360	>255	>175
Elongation (%)	4d	17	22	-	-	-
	5d	17	19	>15	>17	>21
Reduction of area (%)		not specified	60	>68	>75	>80
Impact ISO-V (J)	+20°C	47	65	-	-	-
Lateral expansion	+20°C	not specified	1.00	-	-	-
Hardness (HV)	PWHT	not specified	250	-	-	-

*Minimum strength for parent material is lower than AWS requirement shown.

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-140
4.0 x 450	100-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	125	4.4	CH9MVN-32-2
4.0 x 450	CBOX	80	5.4	CH9MVN-40-2

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.