

LNT 9Cr(P91)

CLASSIFICATION

AWS A5.28	ER90S-B9	A-Nr	5
ISO 21952-A	W CrMo91	F-Nr	6
		9606 FM	4

GENERAL DESCRIPTION

Solid rod for welding of creep and hydrogen resistant 9% Cr, 1% Mo steels
Service temperature up to 650°C

SHIELDING GASES (ACC. ISO 14175)

It	Inert gas Ar (100%)
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CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo	Ni	Nb	V	Cu
0.11	0.8	0.25	8.9	1.0	0.5	0.06	0.2	0.06

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Shielding gas		Condition	Yield strength [N/mm²]	Tensile strength [N/mm²]	Elongation [%]	Impact ISO-V(J) -20°C
Typical values	It	SR 750°C/3h	500	700	18	70

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type	Standard	Type
Creep and hydrogen resistant steels	EN 10222-2 ASTM	X10CrMo V9-1 steels	ASME	
		A199 Grade T91		SA 182-F91
		A200 Grade T91		
		A213 Grade T91		SA 213-T91
		A335 Grade P91		SA 335-P91
		A336 Grade F91		SA 336-F91
				SA 369-FP91
				SA 387-Grade 91
				SA 387-Grade 91

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	2.4	Note : Cut length = 1000 mm
5 kg PE-Tube	X	X	

LNT 9Cr(P91) : rev. C-EN27-12/12/16