

Classifications

EN ISO 17634-B:2008	: T69 T1-1M-9C1MV	AWS A5.29-10	: E91T1-B9M
JIS Z 3318	: T69 T1-1M-9C1MV	AWS A5.36-12	: E91T1-M21PZ-B9

Description

- It is designed for welding of 620MPa 9%Cr-1% Mo-V steels used for high pressure vessels, oil refining industries etc (ASTM A189 Gr. F91, A199 Gr. T91, A200 Gr. T91, A213 Gr. T91, A335 Gr. P91, A369 Gr. FP91, A387 Gr. 91)
- The weld metal contain about 9%Cr-1%Mo-Ni-V component, so excellent creep rupture strength
- It has easy slag removal and good weld soundness

Welding positions**Polarity & shielding gas**

- Mix: Ar+20% CO₂ (15-25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Mo	V
Mix	0.10	0.23	0.72	9.10	1.00	0.18

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	PWHT
AWS A5.29	min. 540	620-830	min. 16	
Example (Mix)	630	680	24	760°Cx2Hr

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- Preheat at 210-310°C and PWHT at 760°C

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		