

GRIDUCT 95B9

IDENTIFICATION: GRIDUCT 95B9 E9015B91

CLASSIFICATION: AWS /SFA 5.5: E9015-B91

WELDING PROPERTIES:

Non-synthetic Hydrogen controlled, heavy coated basic type electrode depositing 9Cr-1Mo-0.2V-N-Nb alloyed weld metal.

Deposited weld metal has improved creep strength toughness and fatigue life and oxidation and corrosion resistance at elevated temperature upto 620°C.

MICROSTRUCTURE:

In PWHT condition, the microstructure consists of tempered martensite.

APPLICATION:

For welding of P91 alloyed steel.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.08-0.12	0.4-0.9	0.2-0.3	0.010 max	0.010 max
Cr	Mo	V	Nb	N
8.0-10.5	0.85-1.20	0.15-0.30	0.02-0.10	0.02-0.07
Cu	Al	Ni	Mn + Ni	
0.25 max	0.04 max	0.8 max	1.20 max	

ALL-WELD MECHANICAL PROPERTIES (PWHT 760±15°C/2hrs.)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact strength	
			Temp	Joules
630 min	530 min	17 min	20°C	27 min

Redrying temperature for electrodes: 350°C/2 hrs

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING/BOX (PCS)	WEIGHT/1000 Pcs (Kg)
2.50	250/300/350	60-90	160x4=640	21.0
3.20/3.15	350	90-140	110x4=440	42.00
4.00	350	130-180	70x4=280	67.00
5.00	350	160-220	45x4=180	100.00

Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West) Thane, Maharashtra, India.
Website: www.geelimited.com

Authorised Distributor: CROSS MARKETING

Head Office: Martin Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India
Ph: (+91) 9163763419 | (+91) 9038320189
Email: lakhotia.ravi@gmail.com | crossmarketingkolkata@gmail.com

<https://crossmarketing.co.in>