

CROMOTHERME-91

CODIFICATION :

AWS : SFA 5.5 E9015-B91

EN ISO : 3580-A E CrMo91 B 4 2

CHARACTERISTICS AND APPLICATIONS:

Cromotherme-91 is 9Cr - 1Mo, non-synthetic, low hydrogen electrode modified with Aluminium, Niobium, Vanadium and Nitrogen designed to provide improved creep strength, toughness, fatigue life, oxidation and corrosion resistance at elevated temperatures. It is designed to weld the materials in power plant and refineries. Following are some of the steels that can be welded with this electrode.

● Plate: A 387 Gr. 91 ● Pipes: A 335 - P91 ● Tubes: A 213 - T91

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL(%):

Element:	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	N	Cu	Al
Percent:	0.10	0.65	0.25	0.007	0.008	9.00	0.45	1.00	0.20	0.06	0.03	0.02	0.02

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 760°C FOR 2 HRS)

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at 20°C (Joules)	Hardness (HV)
690	580	19	60	205

CREEP PROPERTIES: Successfully completed 40119 Hours at 600°C/100 MPa.

DIFFUSIBLE HYDROGEN CONTENT: 4 ml/100 gms of weld metal Max. (When measured according to AWS-4.3-86 Specification)

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x450	4x350	3.15x350	2.5 x 350
Dia x Length					
Current Range (Amps)	:	170-230	130-170	80-120	60-80
Qty.(Pcs./Carton)	:	30	50	75	100

APPROVALS: Adani Infra, BHEL, CE, CIB-MP, Reliance (SASAN Power)

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300°C for 2 hours.
2. Use short arc, minimize heat input.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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