

S-9015.B9

Type : Basic

Conformances

- AWS A5.5/ ASME SFA5.5 E9015-B91
- JIS Z3223 E6215-9C1MV
- EN 1599 - ECrMo91 B 4 2 H5

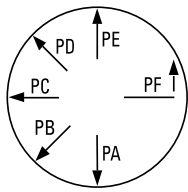
Applications

- Heat resistant steel (9%Cr-1%Mo)

Features

- Good creep resistance at high temperature
- Maximum service temperature at 650°C (1202°F)
- Low-Hydrogen electrode (HDM ≤5ml/100g)
- Good performance with DCEP

Welding Position



Current

DC ±

Redrying Conditions

350~400°C (662~752°F) X
0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
		5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)	✓		✓		✓		✓	
3.2 (1/8)	350 (14)	✓		✓		✓		✓	
4.0 (5/32)	350 (14)	✓		✓		✓		✓	
	400 (16)	✓		✓		✓		✓	
5.0 (3/16)	400 (16)	✓		✓		✓		✓	

SWAW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	N
0.10	0.24	0.90	0.008	0.006	9.25	0.50	0.99	0.25	0.023	0.043

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	Heat Treatment
604 (87,600)	746 (108,200)	22.2	20 (68)	71 (52)	760°C(1400°F) X 2hr. S.R
684 (99,200)	733 (106,300)	25.2	20 (68)	85 (63)	760°C(1400°F) X 4hr. S.R

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)		5.0 (3/16)
Length mm (in)	350 (14)	350 (14)	350 (14)	400 (16)	400 (16)
F & HF	55-90	90-130	130-190	130-190	190-240
V-up, OH	50-80	80-120	120-180	120-180	-