

MIGWELD 91CrMo

MIG/MAG Wires [GMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 21952-A : G CrMo91 AWS A-5.28 : ER 90 S-B9		Power generation industry

- Solid welding wire with the addition of Cr, Mo, V and Nb for MIG/MAG welding.
- Used for welding P91 steels working under pressure.
- Working temperature of the weld metal up to 600°C.

Application

Steam boilers, pipelines, fittings

Base material

ASTM A 335:

P91 (T91)

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	Nb
0,10	0,25	0,50	9,20	0,41	1,00	0,20	0,05

Typical mechanical properties

Yield strength Re [N/mm2]	≥520
Tensile strength Rm [N/mm2]	≥620
Elongation A5 [%]	≥16
Impact energy Kv [J]	>47J (20°C) /
Heat treatment	Annealing: 720°C/30 min, furnace cooling to 300°C, then in air

Welding parameters and packing

Ø	Weight of packet [kg]
0,8	15,0
1,0	15,0
1,2	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl