

**Standards**
**Chemical Composition of  
Welding Wire % (Typical)**

TS EN ISO 21952-A : W CrMo 91

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AWS A5.28/(A5.9) : ER 90 S-B9

C	Si	Mn	Mo	Cr	V	Ni	Nb	N
0.09	0.25	0.6	0.95	9.0	0.2	0.65	0.06	0.05

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Heat Treatment
650	740	min. 60 J	min. 18	745-775°C/1h/300°C air

**Typical Base Material Grades**

- X10CrMoVNb 9-1, A213 Gr. T91, A 335 Gr. P91 (T31), A 139 GR. T91, %9-12 Cr martensitic stainless steels.

**Features and Applications**

- Used for TIG welding of high heat resistance steels such as P91 / T91
- Power plants, turbines, oil refineries, coal and gasification plants, boiler production, also used for the welding of steels with 9Cr 1Mo
- Weld metal is resistant to working temperature up to 600°C
- Shielding gas (TIG): Pure Ar

**Welding Positions**

**Current Type**

TIG D.C.(-)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100368	2.00 x 1000	5/64 x 39"	5	Carton Box
6011100369	2.40 x 1000	3/32 x 39"	5	

**Approvals:** CE, GOST-R , SEPRO