

Standards

TS EN ISO 3580-A	: E CrMo91 B 42 H5
EN ISO 3580-A	: E CrMo91 B 42 H5
AWS A5.5	: E9018-B91 H4

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Cr	Mo	Ni	V	Nb	N
0.09	0.2	0.5	9.0	1.0	0.6	0.2	0.04	+

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)	Heat Treatment
min. 530	min. 620	min. 47 J	17	745-775°C / 2h / 300°C (air)

Typical Base Material Grades

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

Features and Applications

- High- alloyed low-hydrogen electrode with basic-type coating
- Resistance to heat and creep, high resistance to creeping and high toughness values under long-term stress
- Weld metal's resistance to high temperatures up to 620°C
- Pre-heating and inter-pass welding temperature : 200°C - 315°C
- Requirement of re-drying for min. 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C.(+)/ D.C.(-) for root pass

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100873	2.50 x 350	3/32 x 14"	80 - 110	2220
3010100876	3.20 x 350	1 / 8 x 14"	110 - 140	3560
3010100879	4.00 x 350	5/32 x 14 "	140 - 190	5250

Approvals: CE, GOST-R, SEPRO