

**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 <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
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, SEPRO