Standards

AWS A5.5 : E 9018-B92 (mod.)

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Cr	Mo	Ni	V	W
0.08	0.25	0.65	8.5	0.5	0.75	0.2	1.8

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. 550	min. 650	min. 47 J	min. 19	745-775°C / 4h / 300°C (air)

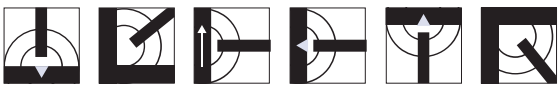
Typical Base Material Grades

- T/P92, 9%Cr, 1.7%W, 0.5%Mo,, creep resisting martensitic steels: ASTM: A213 Gr T92, A 335 Gr P92, A387 Gr 92

Features and Applications

- Recommended for welding of heat resistant steels T/P92 which are used for steam tubing, turbine casings and power generating casts
- Provides creep strength and toughness at elevated temperatures with additional alloying elements
- Weld metal is resistant to temperatures up to +650°C
- Bruscato factor of X<15
- Preheat and interpass 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.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010102273	3.20 x 350	1/8 x 14”	110 - 140	3800

Approvals: SEPRO, CE