Selectarc WELDING

FCW P91B(Modified)

Flux Cored Wire

Classification

AWS A5.29 : E90T5-B9 H4 (modi) ISO 17634-B : T69T5-OG-9C1MV-H5

Characteristics

Highly alloyed basic flux cored wire for shielded metal arc welding. Deposit 9% Cr-1% Mo modified with tungsten, vanadium, niobium, nitrogen and boron additions. Enhanced productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness. HDM <4 ml/100g deposited metal. The tightly controlled weld metal chemistry provides strength, toughness, fatigue life, oxidation resistance and corrosion resistance at elevated temperatures.

Applications

Petrochemical and Chemical industries, Supercritical Boiler, Plates, Pipes.

Base Materials

ASTM	Designation - EN	Material N°
A 213 T 91	X10CrMoVNb9-1	1.4903
A 335 P 91	X10CrMoVNb9-1	1.4903
A 387 Gr. 91		
A 182 F 91		

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Nb	V	N	P	S	Fe
0.10	0.25	0.60	9.00	0.40	1.00	0.05	0.20	0.03	0.008	0.008	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Rp0.2 (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
PWHT	810	740	17	+ 20	80

PWHT : After heat treatment at 760°C / 4hrs

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shieding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
FCAW = +	1.2	120 - 240	24 - 29	15 - 25	M12 (Ar + 0.5-2.5 % Co_2) 10 - 20 l/min

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