



Selectarc B691N

*Basic coated Electrode
For creep resisting steels*

Classification

AWS A5.5 : E9018-B9 EN 1599 : E CrMo91 B 4 2 H5
 AWS A5.5M : E6218-B9 ISO 3580-A : E CrMo91 B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode for welding creep resistant steels of similar chemical composition (known as P91) used at service temperatures up to 620°C. Deposit resisting to temperature and creep up to 620°C. Highly resistant to hot gas and overheated steam.

Main applications: For power plants, heat exchangers, tubes, steam boilers...

Base materials

Plates and pipes for boiler and pressure vessels

Mat. N°	EN	ASTM
1.7386	X12CrMo9-1	A187 Gr F9 ; A336 Gr F9; A335 Gr P9
1.7389	GX12CrMo10-1	A217 C12
1.4903	X10CrMoVNb9-1	A199 gr. T91 ; A335 gr. P91 ; A213 gr T91

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	Nb	N	P	S
0.09	0.25	0.6	9.0	0.6	0.9	0.05	0.2	0.04	0.03	0.01	0.008

All Weld Metal Mechanical Properties *

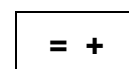
$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
600	720	19	+20°C	80
			0°C	50

* After heat treatment at 760°C/2h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450
Current	(A)	80	115	150

Redrying 1h at 300°C, if necessary. Preheating of joints to weld at 200°C. Interpass temperature: 200-300°C. Slow air-cooling to a temperature below 80°C followed by an annealing at 760°C/2-4h with slow cooling. To achieve improved impact resistance, thin layers with about 2mm thickness should be welded.



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