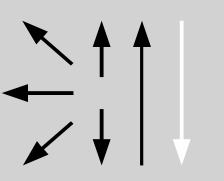


Classifications										
EN ISO 3580-A			EN ISO 3580-B			AWS A5.5		AWS A5.5M		
E Z CrMoWVNb9 0,5 2 B 4 2 H5			E 6215-G			E9015-B92 H4		E6215-B92 H4		
Characteristics and typical fields of application										
<p>The basic coated CrMoWVNb core wire alloyed electrode is specially designed for welding of creep resistant tempered martensitic 9 % Cr steels. The electrode is used for the fabrication of turbine and boiler components in thermal power plants.</p> <p>It features good welding characteristics in all positions except vertical down, a stable arc, low spattering, good slag detachability and excellent striking and re-striking properties.</p> <p>The chemical composition is optimized in order to provide a high creep resistant and ductile weld metal and meets the requirement for restricted Mn + Ni content (≤ 1.2 wt. %). It is characterized by low hydrogen content and low level of trace elements.</p>										
Base materials										
Modified 9Cr-1Mo steels like 1.4901, X10CrWMoVNB9-2, ASTM Grade 92, NF 616										
Typical analysis of all-weld metal										
	C	Si	Mn	Cr	Mo	Ni	V	W	Nb	N
wt.-%	0.11	0.2	0.7	8.8	0.5	0.4	0.2	1.6	0.05	0.05
	Mn + Ni ≤ 1.2									
Mechanical properties of all-weld metal at + 20 °C										
Heat-treatment	Yield strength $R_{p0.2}$		Tensile strength R_m		Elongation A 5		Impact work ISO-V			
	MPa		MPa		%		J			
760 °C / 2 h	≥ 530		≥ 620		≥ 17		> 41			
Operating data										
	Polarity:	Electrode identification:		\varnothing mm	L mm	Amps A				
	DC +	THERMANIT MTS 616-LNi E9015-B9		2.5	250	70 – 100				
				3.2	350	90 – 135				
				4.0	350	130 – 170				
				5.0	450	160 – 240				
Welding instruction										
Preheating / Interpass temperature			Cooling down before PWHT			Post weld heat treatment (PWHT)				
200 – 300 °C			≤ 100 °C			760 \pm 10 °C / 2 h				
Re-drying: 300 – 350 °C / 2 h. Not necessary straight from the tin.										
Approvals										
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