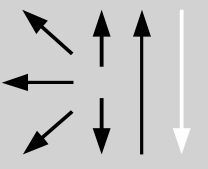


Classifications										
EN ISO 3580-A			EN ISO 3580-B			AWS A5.5		AWS A5.5M		
E Z CrMoWVNb9 0,5 2 B 4 2 H5			E6215-G			E9015-B92 H4		E6215-B92 H4		
Characteristics and typical fields of application										
<p>The basic coated core wire alloyed electrode is specially designed for welding of creep 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 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	0.6	8.8	0.5	0.6	0.2	1.7	0.04	0.04
Mechanical properties of all-weld metal at + 20 °C – typical values (min. values)										
Heat-treatment	Yield strength R _{p0.2}		Tensile strength R _m		Elongation A 5		Impact work ISO-V KV J			
	MPa		MPa		%		+20 °C			
760 °C / 2 h	590 (≥ 530)		730 (≥ 620)		19 (≥ 17)		50 (≥ 41)			
Operating data										
	Polarity:	Electrode identification:				ø mm	L mm	Amps A		
	DC +	Thermanit MTS 616 9015-B92				2.5	300	70 – 100		
						3.2	350	90 – 135		
						4.0	350	130 – 170		
Welding instruction										
Preheating / Interpass temperature			Cooling down before PWHT			Post weld heat treatment (PWHT)				
200 – 300 °C			≤ 100 °C			760 ± 10 °C / 2 h				
Re-drying: 300 – 350 °C / 2 h. Not necessary straight from the tin.										
Approvals										
TÜV (09289), CE										