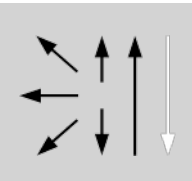


Classifications										
EN ISO 21952-A						AWS A5.28				
GZ CrMoWVNb 9 0.5 1.5						ER90S-G / ER90S-B9(mod.)				
Characteristics and typical fields of application										
High temperature resistant. Suited for joining and surfacing applications with matching high temperature resistant parent metal P92 according to ASTM A 335.										
Base materials										
1.4901 – X10CrWMoVNB9-2; NF 616; ASTM A 355 Gr. P92										
Typical analysis of solid wire (wt.-%)										
	C	Si	Mn	Cr	Mo	Ni	W	V	Nb	N
wt-%	0.1	0.25	0.5	8.5	0.4	0.5	1.6	0.2	0.06	0.04
Structure: Martensite, suitable for quenching and tempering										
Mechanical properties of all-weld metal										
Heat-treatment	Yield strength R _{p0.2}		Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J			
	MPa		MPa		MPa		J			
(760 °C / ≥ 2 h)	560		720		15		41			
Creep rupture properties: According to matching high temperature resistant parent metal										
Operating data										
	Polarity: DC (+)		Shielding gas: (EN ISO 14175) M12, (M13)			ø mm		Spool:		
						0.8		B300		
						1.0		B300		
						1.2		B300		
						1.6		B300		
Welding instruction										
Materials		Preheating			Cooling		Postweld heat treatment			
Matching steels / cast steel grades		200 – 250 °C / 200 – 300 °C (392 – 482 °F / 392 – 572 °F)			≤ 100 °C (212 °F)		Tempering at 760 °C (1400 °F) – at least 2 h / air			