



SELECTARC UP EB9

Creep Resistant Solid SAW Wire

Classification

AWS A5.23 : EB9

ISO 24598-A

: ScMo91

Characteristics

Submerged arc welding wire for welding creep resisting steels of similar chemical composition (known as P91) used at service temperatures upto 650°C. Deposit resisting to temperature and creep upto 620°C. Highly resistant to hot gas and overheated steam.

Applications

For Power plants, Heat exchangers, Tubes, Steam boilers. Construction and Creep resisting steels.

Base Materials

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 WireComposition (%)

C	Si	Mn	Cr	Ni	Mo	V	Nb	P	S	Fe
0.10	0.52	0.50	8.70	0.65	1.00	0.20	0.06	0.007	0.002	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	%Elg
	Rm (MPa)	Rp0.2 (MPa)	A ₅
PWHT	750	640	20

PWHT : After heat treatment at 760°C / 2hrs

Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP WP 380
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

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