

MG-S90B91

Solid wire for 9%Cr-1%Mo-V-Nb steel

Features:

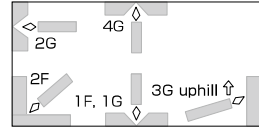
- Applied for ASTM A387 Gr.91 and equivalents
- Excellent creep rupture strength

Classification: AWS A5.28 ER90S-B9

Shielding gas: Ar-2~5%O₂, Ar-5~20%CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool	
1.2	10kg	20kg
Volume mm	240W, 110H, 230L	280W, 110H, 270L

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.12	0.07~0.13
Si	0.23	0.15~0.50
Mn	0.63	1.20
P	0.004	0.010
S	0.005	0.010
Ni	0.15	0.80
Co	0.41	-
Cr	8.38	8.00~10.50
Mo	0.98	0.85~1.20
Cu	0.01	0.20
Nb	0.06	0.02~0.10
V	0.18	0.15~0.30
N	0.04	0.03~0.07
Al	<0.01	0.04
Mn+Ni	0.78	1.50

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F	2G, 3G uphill, 4G
1.2	260~320	140~200

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	590	414min.
TS (MPa)	730	621min.
EI on 4d (%)	23	15min.
IV 0°C (J)	30	-
PWHT (°Cxh)	760x2	760±15x2
SG	Ar-5%CO ₂	Ar-5%CO ₂