

MIDALLOY CHROMAX E9015-B9 H4 COATED ELECTRODE

CLASSIFICATION

- AWS 5.5 CLASS E9015-B9 H4/ASME SFA 5.5 E9015-B H4

DESCRIPTION

- Midalloy Chromax E9015-B9 H4 is an “out of position” electrode with a globular transfer particularly suited for pipe welding.

APPLICATIONS

- For joining applications on higher chromium 9CrMoNb steel (P91).
- These types of steels are used in piping systems where elevated temperatures and pressures are required.
- This alloy offers improved toughness and better creep properties, which ultimately allow for higher steam temperatures and the use of thinner wall piping.

TYPICAL CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cb	Cu	V
.09	.97	.20	9.5	.10	.95	.01	.01	.05	.04	.01	.21

TYPICAL MECHANICAL PROPERTIES

Heat-treated @ 1400° for 2 hours, air-cooled to room temperature.

TENSILE STRENGTH	138,300 PSI
YEILD STRENGTH	121,800 PSI
ELONGATION	17%
CHARPY IMPACT (V-NOTCH)	29-35 FT. LBS.

WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
AMPS				
-FLAT	90-110	120-145	155-190	200-235
-OUT OF POSITION	80-105	100-130	145-180	
VOLTAGE	22 TO 28	22 TO 28	22 TO 28	22 TO 28

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb .can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

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