



MODI FC 91TB9 FOR HEAT RESISTING STEEL

TYPICAL APPLICATIONS : Butt and fillet welding of 9% Cr - 1% Mo-Ni-V steel used for high pressure boilers, chemical and oil refinery plants. It is applied for ASTM A189-F91, A199-T91, A200-T91, A213-T91, A335-P91, A369-FP91, A387-Gr91 and equivalents.

CHARACTERISTICS :

1. All-position welding provide the metal of 9% Cr - 1% Mo-Ni-V-Nb.
2. Excellent creep rupture strength, easy slag removal and good weld soundness.
3. The shielding gas should be used 80% Ar + 20% CO₂ for welding.
4. Pre-heat at 200-350°C and postheat at 720-780°C.
5. Wire should be used as soon as possible after taking out from package.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%) :

C	Si	Mn	Cr	Mo	Ni	V	Nb	N
0.12	0.25	0.72	10.3	1.0	0.7	0.19	0.03	0.04

TYPICAL MECHANICAL PROPERTIES OF ALL WELD-METAL :

Ultimate Tensile Strength N/mm ² (Kg/mm ²)	Elongation (%)	PWHT
810(82)	15	760°C x 2 hr

CURRENT CONDITIONS : Use DC (+)

SIZE (mm) : 1.2

AMPS : 120-280



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