

ROYAL –ER 90SB9 (ER 90SB9)

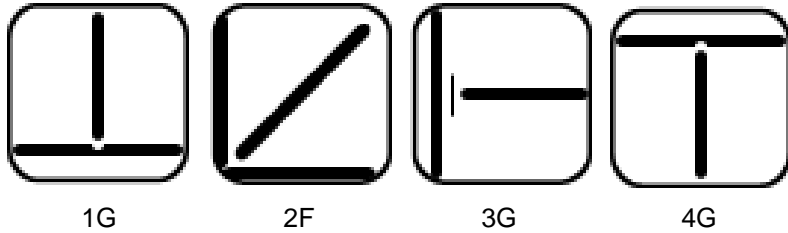
AWS –SFA A 5.28 ER 90SB9

Applications

It gives 9.0 % Chromium and 1.0 % Molybdenum wires modified with Niobium and vanadium to provide strength , toughness , fatigue life, oxidation, resistance and corrosion resistance at elevated temperature. After completion of welding with this filler wire rod, preheat and post weld heat treatments are required.

Characteristics on Usage

It is used for welding base material of similar composition Usually in the form of pipe or tubing.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Mo%	Ni %	Cr%	Cu%	V%
0.07-0.13	1.20 Max	0.15-0.50	0.010 Max	0.010 Max	0.85-1.20	0.80 Max	8.0-1.05	0.20 Max	0.15-0.30
Al%	Nb / Cb%	N%							
0.04 Max	0.02-0.10	0.03-0.07							

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 30° C (J)
620 Min	410 Min.	16.0 % Min	30 Joules Min

Packing

Each Packets content 5 kg of Wire Rods having length 1000 mm.