

Dual Shield B9

AWS A5.29 E91T1-B9C/M

Description and Application

- Dual Shield B9 is an all-position flux cored electrode designed for the welding of modified 9% chromium creep resisting steels, such as ASTM A335 Grade P91 or ASTM A213 T91. This product formulated with a combined Mn & Ni <1.20% to meet stringent customer specifications.

Flux
CORED
WIRES

Shielding Gas : 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	PWHT
682 (69)	748 (76)	21	750 °C×3hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.10	0.70	0.25	9.0	1.0