



ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,
OKHLA INDUSTRIAL AREA, PHASE – II
NEW DELHI – 110020

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KISWEL K-91TB9

Classifications:

AWS A5.29-07 : E91T1-B9M

Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Mo	V
Ar + 20%CO ₂	0.08 – 0.13	<0.50	<1.20	8.00 – 10.50	0.85 – 1.20	0.15 – 0.30

Description:

- It is designed for welding of 620MPa 9%Cr-1% Mo-V steels used for high pressure vessels, oil refining industries etc (ASTM A189 Gr. F91, A199 Gr. T91, A200 Gr. T91, A213 Gr. T91, A335 Gr. P91, A369 Gr. FP91, A387 Gr. 910)
- The weld metal contains about 9%Cr-1%Mo-Ni-V component, so excellent creep rupture strength.
- It has easy slag removal and good weld soundness.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 540	620~760	min. 17