



KISWEL

KISWEL K-91TB9

Classifications:

AWS A5.29: E91T1-B9M

AWS A5.36: E91T1-M21PZ-B9

JIS Z 3183: T69 T1-1M-9C1MV

EN ISO 17634-A: T69 T1-1M-9C1MV

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Mo	V	Nb
0.08 – 0.13	<0.50	<1.20	8.00 – 10.50	0.85 – 1.20	0.15 – 0.30	0.02 – 0.10

Description:

- It is designed for welding of 650MPa 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 and offers 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	min. 620	min. 18

Welding Parameters:

Wire Diameter	Welding Position	Shielding Gas	Current (A)		Voltage (V)	
			Min.	Max.	Min.	Max.
1.20 mm	F, HF	Ar+20%CO ₂	220	280	25	30
1.20 mm	VU		200	240	25	28
1.20 mm	OH		160	220	23	28



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