



## KISWEL – KD-B9

### Classifications:

AWS A5.23: EB91  
EN 24598-A: S CrMo91 FB

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Mo	V
0.07 – 0.13	0.15 – 0.50	0.40 – 0.80	8.50 – 9.50	0.40 -0.80	0.85 – 1.10	0.15 – 0.25

### Description:

- For butt and fillet welding in power plants, turbines and boiler fabrication for 9%Cr-1.00%Mo-V (T91/P91) heat-resistant steel.
- It has easy slag removal and good weld soundness.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 415	min. 620	min. 16	50 (20°C)

### Packaging:

**SAW Wire** (Ø in mm): 2.40 MM / 3.20 MM / 4.00 MM / 4.80 MM in 25.00 Kg Spools

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
2.40 mm		250	500	28	32
3.20 mm		300	650	28	32
4.00 mm	-	400	1200	30	34
4.80 mm		500	1400	32	36



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