

JACKSUN ULTRA-CR9 SPL

LOW HYDROGEN TYPE ELECTRODE IS DESIGNED TO
WELD EQUIVALENT 'TYPE 91' 9CR1MO STEELS

BASIC ALLOY: FE, CR, MO, N, CB, V
AWS/SFA-5.5: E 9015 B9
EN 1599 ECRMO91 B 4 2 H5

KEY FEATURES:

ROWELD-CR9 Spl is low hydrogen type electrode is designed to weld equivalent 'type 91' 9CrMo steels modified with small additions of niobium, vanadium and nitrogen give improved long term creep properties. Its usability is good performance by DCEP current and very low hydrogen electrode. (HDM ≤ 5ml/100g)

APPLICATIONS

- Used for Welding of 9%Cr-1%Mo heat resistant steel.
- Used for pipes of boilers for power plant, equipment for oil refining industries, and high temperature synthetic chemical industries.
- Suitable for fabricating which made by martensitic heat treating steels.
- Both preheating and interpass temperature should be 232-288°C and the weld zone should be tempered at 730-760°C for 6 hours after welding

RE-DRY CONDITION:

- Re-Dry the electrode at -350°C for one hour before use.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cu	Cr	Mo
0.070- 0.13	1.20 max.	0.15-0.50	0.010 Max	0.010 Max	0.20 Max	8.00-10.50	0.85-1.20
N	Nb	V	Ni	Al			
0.07-0.07	0.02-0.10	0.15-0.30	0.80 max	0.040 max.			

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)
540 min.	620 Min.	17 min

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	70-100	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20