CROMOCORD 91

TOP FEATURES

- Long term use approved up to +650°C.
- The fine tuning of the weld metal chemistry allows to guarantee very low impurities. Ni+Mn restriction increases Ac1 to avoid harmful microstructure transformation during PWHT.
- The CROMOCORD 91 offers excellent operability in all position welding except vertical down.
- Stable arc with low spatter, excellent slag removal and bead shape.
- Preheat min. 200°C, Interpass max. 280°C.
- Efficiency about 120%.

CLASSIFICATION

AWS A5.5	E9018-B91 H4
EN ISO 3580-A	E (CrMo91) B 42 H5
EN ISO 3580-B	E (62XX-9C1MV) B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N
0.1	0.6	0.25	0.01	0.008	9	0.5	1	0.05	0.20	0.05

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-B	PWHT	≥530	≥620	≥15	not specified
Typical values	760°C x 2h	640	770	22	65

* PWHT: Postweld Heat Treatment 745-755°C / min 1h

Preheat and interpass temperature: 215-315°C

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-95
3.2 x 350	90-120
4.0 x 350	135-165
5.0 x 450	170-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	100	2.1	W100287717
3.2 x 350	VPMD	55	1.9	W100287718
4.0 x 350	VPMD	35	1.9	W100287719
5.0 x 450	VPMD	20	2.1	W100287720

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.