DevTek 91-B9

Low Alloy Cr-Mo Flux Cored Wire

AWS A5.29 – E91T1-B9M, ASME SFA 5.29 – E91T1-B9M

Typical Applications:

- Designed for 9%Cr - 1%Mo Steels such as ASTM A387 Gr. 91, A335 P91 piping, A213 T91.
- Repair and Maintenance of Castings per ASME SA-217 Grade C12A.
- Boiler and Pressure Vessels
- Power Piping, Steam Generation, Petrochemical

Product Advantages:

- All Position – Flat, Horizontal, Vertical
- Smooth Arc with low spatter
- Flat bead with easy slag release
- Low moisture pick-up

Typical Mechanical Properties - Stress Relieved 2hr @ 1400°F			
	UTS (ksi)	Yield (ksi)	%El
AWS Spec.	90-120	78	16
DevTek 91-B9	113	98	19

Typical Deposit Composition									
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu	%V	%Nb
AWS Spec. (Max.)	0.08–0.13	1.20	0.50	0.80	0.85-1.20	8.0-10.5	0.25	0.15–0.30	0.02-0.10

Available Diameters: 1/16” (Additional sizes may be available upon request)

Typical Welding Parameters			
Diameter	Amperage Range	Voltage	Current
1/16”	225 - 275	27	DCEP

Packaging: The product is packaged on 25 or 50lb. spools with a vapor corrosion inhibitor strip, vacuum-packaged and placed in a specially designed carton for long term storage.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec**. Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.
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