

# TALARC B9 TIG

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER90S-B9	EN ISO 21952-A: W CrMo91

## ALLOY TYPE

9Cr1Mo modified for the welding of creep resistant steel (0,5Ni, Nb, V, N).

## APPLICATIONS

Copper-free tig rod suitable for the welding of creep resistant steel. It will find applications in petro-chemical industry for welding P91 steels. Long term creep properties get improved thanks to small additions of niobium, vanadium and nitrogen. This rod is designed for elevated temperature service up to 650°C. It is used in fossil fuelled power generating plants for components such as headers, main steam piping and turbine casings.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	V %	Nb %	N %
0.09	0.60	0.25	0.007	0.002	8.80	0.65	0.95	0.03	0.20	0.06	0.05

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
Argon	after PWHT	650	750	18	-	-	-	-	-

## WELDING GUIDELINES

Preheat and interpass temperature 200 ÷ 300°C. PWHT at 760°C for two hours. In multipass welding it is recommended to clean accurately the surface of the material to be welded by grinding off the surface layer of chrome oxide.

## TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)

Welding positions: all positions



## WELDING PARAMETERS and PACKAGING DATA

Diameter (mm)	1.6	2.4
Length (mm)	1000	
Carton	5 Kg	
Current	DC - Straight (-) polarity	

Diam.	5kg Tube
1.6mm	INTB916
2.4mm	INTB924

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