Dual Shield B9

Dual Shield B9 is an all-position flux cored wire designed for the welding of modified 9% chromium - 1% molybdenum creep resisting steels, such as ASTM A335 Grade P91 or ASTM A213 T91. This product is formulated with a combined Mn & Ni < 1.20% to meet stringent customer specifications.

Specifications	
Classifications	SFA/AWS A5.29 : E91T1-B9M

Welding Current	DC+
Alloy Type	Alloyed steel (9 % Cr - 1 % Mo - V - Nb - N)
CTOD-Tested	false

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
Stress Relieved 2 hour(s) 760 °C	600 MPa	738 MPa	21 %

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**V**	**N**	**Nb**	**X-bar**
0.10	0.96	0.18	0.15	9.25	1.00	0.22	0.04	0.04	< 15 ppm

Deposition Data		
Diameter	**Current**	**Voltage**
1.2 mm	150-330 A	22-34 V
1.6 mm	170-430 A	24-36 V