HEAT RESISTING STEEL

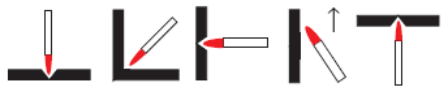
GLST-98B9 ELECTRODE

Classification: AWS A5.5M E6218-B9
EN E Cr Mo 91 B 42

Characteristics and Application:

GLST-98B9 is an iron powder and low hydrogen type stick electrode for all-position welding, in which weld metal chemical composition is 9%Cr-1%Mo It provide reliable creep rupture properties for high temperature service at 550-650 ℃. It is applicable in A213-T91, A335-P91and A387 Gr.91.

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Mo	P	S
AWS	0.08-0.13	1.20	030	8.0-10.5	0.85-1.20	0.01	0.01
Type Value	0.081	0.60	0.20	9.40	1.02	0.009	0.007

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/℃	PWHT
AWS	530	620	17	27/20	740℃±15℃/1hr.
Type Value	620	730	23	80/20	740℃±15℃/1hr.

Notes on Usage:

1 Dry the stick electrodes at 350-400℃ for one hour before welding.

2 Preheating and interpass temperature at 232-288℃ and try to keep interpass temperature.

3 Keep short arc length when welding.To avoid blowholes when striking the arc, please use backstep method welding technique during welding process.

4 To relieve stress, PWHT at 740℃±15℃.

5 Current type:DC or AC

6 Keep low hydrogen situation during whole welding proess.

7 Because of excessive heat input, the impact value tends to be lower. Therefore, choose proper heat input is very important.

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×400	5.0×450
Current/Amp	F	55-85	90-130	140-1890	190-240
	V, OH	50-80	80-120	120-160	-