

SMAW Electrodes

GL98-B91

AWS A5.5 E9018-B91 / AWS A5.5M E6218-B91
JIS Z 3223 E6218-9C1MV

Product Features:

- GL98-B9 is a low hydrogen type electrodes for low alloy heat resistant steel which has good weldability at all positions.
- The deposited metal contains 9%Cr-1.0%Mo alloy elements.
- Additional elements such as Nb and V which are designed to provide improved creep strength, toughness fatigue and oxidation, and corrosion resistance at elevated temperatures.

Applications:

- Suitable for welding of 9%Cr-1.0%Mo such as T91, P91 or Gr.91.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	Nb	V	N	Cu
0.10	0.13	0.84	0.009	0.006	0.44	9.69	1.06	0.03	0.19	0.05	0.01

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	PWHT °C x 2hr
740	826	21.0	760

Size (mm) & recommended welding parameters (A) AC & DC+/-

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450
Flat position	70~100	100~130	150~180	170~210
Vertical / overhead position	60~90	80~110	120~150	140~190

Note:

- 300~350°C x 1 hr baking prior to use.
- Keep the arc as short as possible.
- To control the welding current within the recommended range.

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