Unibraze 9015-B9

Specifications: AWS A5.5M/ASME SFA 5.5 Class E9015-B91 H4R

Description: Unibraze 9015-B9 is an all position low alloy, low hydrogen electrode used to weld P91 and T91 9%Cr/1%Mo steels. It provides improved creep strength, toughness fatigue and oxidation and corrosion resistance at elevated temperatures. Applications include power generation, steam piping and equipment, oil refineries, coal liquefaction plants, and gasification plants.

Typical Chemistry

C	Mn	Si	S	P	Cr	*Ni*	*Mo*	Nb	V	Cu	Al	As	Sn	Sb	N
.09	.68	.23	.006	.01	9.5	*.26*	*1.0*	.04	.20	.02	.005	.001	.004	.001	.05

Note: Fx = (10P + 5Sb + 4Sn + As) / 100 (elements in ppm)

Typical Mechanical Properties (all weld metal) PWHT 2.0 hrs. @ 760°C (1400°F)

Tensile Testing						Impact Testing	
Temp °C	Rp0.2 MPa	Rm MPa	A4%	A5%	*Z%*	Temp °C	KV (J)
20	590	710	23	20	*63*	*1.0*	75

Hardness	
Condition	HV
PWHT	241

Typical Operating Procedures (AC/DC+)

Diameter	Amps
3/32”	70-110
1/8”	80-140
5/32”	100-180
3/16”	140-240

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus, the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.