

TIG Rods C-Mn steels and low-alloy steels

CARBOROD KV7M is an uncoated WCrMo91/ER90S-B9 type solid TIG welding rod for welding creep resisting steels of the type 9Cr 1Mo V Nb N. Suitable for use with Ar shielding gas.

CARBOROD KV7M is especially designed for the ASTM steels T91/P91. Approved in long-term service at temperatures <650°C.

Improved creep strength is obtained by the addition of nitrogen, niobium and vanadium.

Classification	
EN ISO	21952-A: W CrMo91
AWS	A5.28: ER 90S-B9

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Nb	V
0.10	0.6	0.20	9.0	0.9	1.0	0.06	0.20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
760 °C x 2h / Ofen bis 300 °C / Luft	≥ 560	≥ 650	≥ 17	≥ 50








Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

1.4903; X10CrMoV 9-1, X10CrMoVNb9-1; A199 T91, A200 T91, A213 T91, A355 P91, A336 P91

Storage
Keep dry and avoid condensation

Current condition and welding position						
DC-						
						
PA	PB	PC	PD	PE	PF	PG

Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●