

Basic coated MMA electrode for welding high-temperature creep resistant steels of type 9Cr-0.5Mo-W-V-Nb-N with operating temperatures <650°C. CROMOCORD 92 is particularly suitable for welding components with a post weld tempering treatment at 760°C.

Classification

EN ISO	3580-A: E Z CrMoWVNb 9 0.5 2 B 4 2 H5
AWS	A5.5: E 9018-G

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo	Nb	Co	V	W	N
0.095	1.1	0.2	≤0.012	≤0.012	9	0.5	0.05	1.0	0.20	1.7	0.04

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 4h/furnace	≥530	≥ 700	≥16	≥50

Materials

A 387 Gr.92, A 182 F92, A 369 FP 92F

X10CrMoWVNb9-2, A 213 T92, A 335 P92

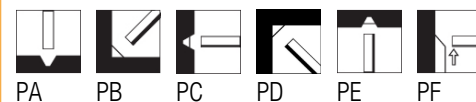
Storage

Keep dry and avoid condensation.

HD = 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	350	65-95	21.7	185	●	90	●
3.2	350	85-135	37.1	105	●	50	●
4.0	350	140-180	55.6	70	●	30	●