## Standards:

| | |
|---|---|
| EN ISO 3580-A: | E CrMoWV 9 1 1 B 42 |
| EN 1599: | E CrMoWV 9 1 1 B 42 |
| AWS SFA-5.5: | ~E 9015-B9 |
| **Recovery:** | **130%** |

# capilla® P 911

## Product description:

CrMoNiVWNb-alloyed basic coated stick electrode, good welding characteristics producing a creep and rupture resistant high temperature weld metal matching similar alloyed base metals

## Applications:

For welding of high temperature resistant martensitic Cr-steels

Base materials:

1.4905 (X11CrNiWVNb 9-1-1), E 911,
ASTM A355 Gr. 911 (T911),
ASTM A213 Gr. T911.

## Typical weld metal composition:

[wt. - %]

| | C | Mn | Si | Cr | Mo | Ni | Nb | W | Fe |
|---|---|---|---|---|---|---|---|---|---|
| **Min.** | | **0,6** | | **8,5** | **0,9** | **0,6** | | **0,9** | |
| **Max.** | **0,11** | **0,7** | **0,25** | **9,5** | **1,1** | **0,8** | **0,05** | **1,1** | **Bal.** |

## Mechanical properties:

(Heat treatment: 760°C/2h; Minimum values at ambient temperature)

| | | |
|---|---|---|
| Tensile strength $R_m$: | 720 | [MPa] |
| Yield strength $R_{p0,2}$: | 550 | [MPa] |
| Yield strength $R_{p1,0}$: | - | [MPa] |
| Elongation (L=5d): | 15 | [%] |
| Impact strength (ISO-V): | 41 | [J] |

Positions: all except PD, PE and PG

Redrying: min. 320°C/2h

**Dimension:**

| Ø [mm] | Length [mm] | Welding current [A] |
|---|---|---|
| 2,5 | 350 | 60 – 90 |
| 3,25 | 350 | 80 – 120 |
| 4,0 | 350 | 110 – 170 |

**Polarity** =(+)