Standards:

EN ISO 3580-A:	E CrMoWV 9 0,5 2 B 42
EN 1599:	E CrMoWV 9 0,5 2 B 42
AWS SFA-5.5:	~E 9015-B9
Recovery:	**130%**

capilla® P 92

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:

ASTM A355 Gr. 92 (T92),
NF 616

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Ni	V	W	N	Nb	Fe
Min.	**0,9**	**0,6**		**8,5**	**0,5**	**0,6**	**0,18**	**1,3**	**0,04**	**0,05**	
Max.	**0,12**	**0,7**	**0,4**	**9,5**	**0,7**	**0,8**	**0,24**	**1,6**	**0,07**	**0,07**	**Bal.**

Mechanical properties:

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

Tensile strength R_m:	720	[MPa]
Yield strength $R_{p0,2}$:	560	[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 – 110
4,0	350	100 – 150

Polarity
=(+)