



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality
Management System is
Certified to **ISO 9001:2008**
Cert # 05-R0925

9015-B9, 9018-B9 Low-Alloy Steel Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

USA901X-B9 is 9% Cr- 1% Mo covered electrodes commonly used in maintenance and fabrication of base metals in the power generation, steam piping and equipment found in elevated operating temperatures. The low hydrogen powder covering has good deposition with smooth arc, low spatter and easy slag removal. Typical base metals such as T-91, P-91, and other similar composition are idea for this filler metal.

TYPICAL WELDING PROCEDURES; OPTIMUM IN BOLD

Diameter	3/32"	1/8"	5/32"	3/16"	1/4"
Length	14"	14"	14"	14"	18"
Amps Flat	70- 90 -100	90- 140 -160	130- 165 -220	190- 245 -290	295- 345 -400
Vertical up & Overhead	60- 85 -90	80- 110 -120	110- 145 -170		

Arc Length = Very short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

9015-B9 = Low-hydrogen sodium coating /DCEP

9018-B9 = Low-hydrogen potassium, iron powder coating /DCEP or ac

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.
Preheat and postheat recommended

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.		AWS Spec PWHT
Carbon	0.08-0.13	Tensile Strength (psi)	90,000 min.
Manganese ⁽¹⁾	1.20 max	Yield Strength (psi)	77,000
Silicon	0.30 max	Elongation in 2"	17 % min.
Phosphorus	0.010 max.		
Sulfur	0.010 max.	Vanadium	0.15-0.30
Nickel ⁽¹⁾	0.80 max.	Columbium (Nb)	0.02-0.10
Chromium	8.00-10.50	Nitrogen	0.02-0.07
Molybdenum	0.85-1.20	Copper	0.25 max
Aluminum	0.04 max	⁽¹⁾ Manganese + Nickel shall be 1.50 max	

AVAILABLE SIZES: TE 9015-B9 = 10 # containers of 3/32, 1/8, 5/32, 3/16

TE 9018-B9 = 10 # containers of 1/8, 3/16,

Other sizes may be available (3/32 X 8# containers) – please inquire

SPECIFICATIONS; ANSI/AWS A5.5 E9015-B9, 9018-B9
ASME SFA A5.5 E9015-B9, 9018-B9

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