



Quality Management System  
in accordance with  
**ISO 9001:2000**  
Cert # 05-R0925

# 9015-B9 Low-Alloy Steel Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



### ALLOY DESCRIPTION AND APPLICATION;

USA9015-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 sodium 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; DCEP OPTIMUM IN BOLD

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

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

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 <sup>(1)</sup>	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 <sup>(1)</sup>	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	<sup>(1)</sup> Manganese + Nickel shall be 1.50 max	

**AVAILABLE SIZES:** TE 9015-B9 = 10 # containers of 3/32, 1/8, 5/32, 3/16  
Other sizes may be available – please inquire

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

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9-2007 DC

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