



WBP91-MC METAL CORED WELDING WIRE

Classifications	AWS A5.28: E90C-B9MH4 BS EN ISO 17634-B: T69T15-OM-9C1MV-H5											
Product Description	Copper coated, seamless tubular, metal cored, welding wire. Fully positional in short circuit metal transfer.											
Applications	<p>WBP91-MC is ideal for P91 applications. Excellent deposition rates due to metal powder technology.</p> <p>Tubular technology & copper coating ensures very low weld metal hydrogen levels (<3ml/100g) coupled with excellent current tip transfer. Excellent welder appeal including deslag and low spatter levels.</p> <p>Suitable for welding modified 9%Cr/Mo 0.2%V creep-resisting steels. The addition of small amounts of Vanadium and Nitrogen improve long term creep properties. Used mainly by the power engineering industry for headers, steam piping and turbine rotors.</p> <p>Typical material grades:- A213-T91, DIN 1.4903, A335 P91, A387 Gr. 91, A182 F91, A217 C12A.</p>											
Wire Composition (Wt. %)		C	Mn	Si	S	P	Cr	Ni	Mo	V	N	Nb
min.		0.08	0.75	0.25	-	-	8.0	0.40	0.85	0.15	0.02	0.03
max.		0.10	1.20	0.55	0.015	0.020	10.5	0.80	1.20	0.30	0.07	0.07
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²		690				
	Yield Stress/0.2% Proof Stress					N/mm ²		565				
	Elongation on 5D					%		24				
	Impact Energy CV @ +20°C					Joules		75				
	PHWT @ 760°C/1 hour											

Wire Dia. (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	150	160	180	-	-
	max.	-	-	200	300	380	-	-
Volt Range (Volts)	min.	-	-	17	18	20	-	-
	max.	-	-	22	28	30	-	-
Packaging Information								
Kg Per Reel		-	-	16	16	16	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas CO ₂ or Argon/CO ₂ mixture Flow Rate 15-20 L/min							

Current Conditions DC+ and Welding Positions

