PF-90B91/US-90B91 TRUSTARC™

Flux and wire combination for 9%Cr-1%Mo-V-Nb steel

Features:
- Applied for ASTM A387 Gr.91 and equivalents
- Excellent creep rupture strength

Classification: AWS A5.23 F9PZ-EB91-B91

Type of flux: Bonded
Redrying of flux: 200~300℃x1h
Polarity: DCEP

Packaging data

Flux	Mesh	Can
PF-90B91	10x48	20kg
Volume mm		240W, 350H, 240L
Wire	**ϕ mm**	**Coil**
US-90B91	2.4 3.2	25kg 25kg
Volume mm		430W, 90H, 430L

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.11	0.07~0.13
Si	0.29	0.50
Mn	0.51	1.00
P	0.005	0.015
S	0.004	0.015
Cu	<0.01	0.10
Ni	0.14	1.00
Cr	8.95	8.5~10.5
Mo	1.00	0.85~1.15
V	0.19	0.15~0.25
Al	<0.002	0.04
Nb	0.06	0.02~0.10
N	0.04	0.03~0.07
Mn+Ni	0.65	1.40
Co	0.39	-

Note: [a] Single values are maximum.

Composition (weld metal mass%)

	Typical	Guaranty [a]
C	0.08	0.08~0.13
Si	0.26	0.80
Mn	0.72	1.20
P	0.005	0.010
S	0.005	0.010
Cu	0.01	0.25
Ni	0.12	0.80
Cr	8.93	8.0~10.5
Mo	1.01	0.85~1.20
V	0.18	0.15~0.25
Al	0.01	0.04
Nb	0.05	0.02~0.10
N	0.04	0.02~0.07
Mn+Ni	0.84	1.40
Co	0.36	-

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	590	538min.
TS (MPa)	730	621~758
El on 4d (%)	25	17min.
PWHT (℃xh)	760x2	760±15x2