

CITOFLEX M91

Cored Wires Chromium-Molybdenum steels

Citoflex M91 is a metal cored wire for creep resistant steels of the type 9% Cr, 1%Mo, 0.25% V. Used in all positions. The main applications are petrochemical plant and power generation.

Classification	
AWS	A 5.22: E505 T-G H4
EN	12071: TZ MM 1 H5

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.11	1	0.35	≤ 0.015	≤ 0.015	9.30	0.09	1	0.06	0.25	0.048	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
PWHT 760°C x 2h	≥ 415	≥ 710	≥ 22	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

T 91 (ASTM A 213), F 91 (ASTM A 182)

X10CrMoVNb9-1, grade 91 (ASTM A 387), P 91 (ASTM A 335)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC +



PA PB PC

Packaging data: K300 kg, 16

Diameters	1,2					
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