DURAMAX®
Inspiring the future generations of welders

PRODUCT DATA SHEET

DM9015-B9 Premium Electrode

Classification: **E9015-B9**

AWS A 5.5 / ASME SFA 5.5

DuraMax DM9015-B9 is a LOW HYDROGEN SODIUM COVERED ELECTRODE

Characteristics

DM9015-B9 is a 9.0% Cr - 1.0%Mo, low hydrogen electrode modified with niobium and vanadium. It is designed to provide improved creep strength, toughness, fatigue life, and oxidation and corrosion resistance at elevated temperatures.

Typical Applications on Usage

1) For joining applications on higher chromium 9CrMoNb steel
2) Intended for high integrity structural service at elevated temperatures.
3) DM9015-B9 offers improved toughness and better creep properties, which ultimately allow for higher steam temperatures and the use of thinner wall piping.
4) Power plants, steam boilers.

RE-DRY CONDITIONS: Re-Dry the electrode at 250°C for 1 hour before use.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni
0.08 - 0.12	0.40 - 0.75	0.30 max	0.01 max	0.01 max	0.2 - 0.4
Cr	**Mo**	**Nb**	**V**	**Cu**	**Al**
8.0 - 10.0	0.85 - 1.2	0.03 - 0.07	0.15 - 0.25	0.25 max	0.04 max

All Weld Mechanical Properties:

YS (N/mm²)	UTS (N/mm²)	EL % in 2"
690	758	18

Sizes available and recommended currents (DC+)

SIZE	3/32 x 14"	1/8 x 14" / 18"	5/32 x 18"	3/16 x 18"
Current Condition	70 ~ 110	80 ~ 140	100 ~ 180	140 ~ 240

POLARITY: DCEP
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930