

<b>Base Material:</b>	SA-335 Gr. P9	to: SA-335 Gr. P9
<b>Alloy Designation:</b>	K90941	K90941
<b>Principal Composition:</b>	9Cr-1Mo	9Cr-1Mo
<b>P-Number:</b>	5B	5B
<b>Group No.:</b>	1	1
<b>Preheat Temperature:</b>	177 C (350 F)	
<b>Filler Wire (GTAW):</b>	ER80S-B8	
<b>F-Number:</b>	6	
<b>A-Number:</b>	5	
<b>AWS:</b>	5.28	
<b>Interpass temperature:</b>	316 C (600 F) max. Not mentioned in ASME B31.3, taken from API 582	
<b>Electrode (SMAW):</b>	E8018-B8	
<b>F-Number:</b>	4	
<b>A-Number:</b>	5	
<b>AWS:</b>	5.5	
<b>Postweld Heat Treatment:</b>	704 - 760 C (1300 - 1400 F) for t > 13 mm (1/2 in.) or for material with Chromium content greater than 3% or carbon content greater than 0.15%. Apply heat treatment for 1hr/25 mm (1 in.). Minimum holding time is 2 hours. Check hardness after heat treatment which should not exceed 241 BHN.	

**General Comments:**