

❖ Product Description

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| I. Gas shielded, rutile type FCW wire | IV. Stable arc and easy slag removal |
| II. Low fumes, very less spatter | V. The deposit is low alloy steel Cr-Mo |
| III. Excellent mechanical properties | VI. Radiographic weld quality |

❖ Range of Application

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|---|---|
| I. Extremely good for welding of 2.25Cr-0.5Mo, 2.25Cr-1Mo creep resistant steels | III. For joining P5A materials |
| II. Also suitable for Cr-Mo and Cr-Mo-V bearing steels for high temperature application | IV. Finds usage in refineries, power plant, pressure vessels, boilers |

❖ Classification

- AWS/SFA 5.29 E91T1-B3C

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Cr
E91T1-B3C	Min	0.05	-	-	-	-	0.90	2.0
	Max	0.12	1.25	0.80	0.030	0.030	1.20	2.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
PWHT	620	540	17	-

❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 18-25lit/min

❖ Packaging

- Standard packaging in 15kg Spool form

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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