

# STRONG FCAW E91T1-B3C

CLASSIFICATION: AWS SFA 5.29 E91T1-B3C

LOW ALLOY FLUX CORED ARC WELDING WIRE



## CHARACTERISTICS

STRONG FCAW E91T1-B3C is a rutile type all position low alloy (2.25% Cr - 1.0% Mo) gas shielded flux cored welding wire that gives smooth weld bead, minimal spatter, low fumes, easy slag removal and radiographic quality weld metal.

This wire is suitable for high temperature and pressure service conditions up to 600°C.

## APPLICATIONS

STRONG FCAW E91T1-B3C is designed for all position single and multi-pass welding of 2.25Cr-0.5Mo, 2.25Cr-1.0Mo steels. Joining P5A - ASTM A 335 Gr.P22, A 387 Gr.22 materials.

Suitable for welding application in steam production plants, boiler plants, electric power plants etc.

## TYPICAL WELD METAL CHEMISTRY (%)

C	Mn	Si	P	S	Cr	Mo
0.05-0.12	1.25 MAX	0.80 MAX	0.025 MAX	0.025 MAX	2.00-2.50	0.90-1.20

## ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.29	Y.S. MPa	U.T.S. MPa	ELONGATION %
Typical Results PWHT: 690°C for 1 Hr	540	720	17

## PACKAGING SPECIFICATIONS - FCAW

DIA SIZE 1.20MM / 1.60MM

SPOOL WEIGHT 15KGS