K-91TB3

AWS E91T1-B3
JIS YF2CM-C
KS YF2CM-C

FOR HEAT-RESISTING STEEL

Typical applications

K-91TB3 is formulated for butt and fillet welding of 2.25%Cr-1.0%Mo steels used for high pressure vessels, oil refining industries, steam pipes of boilers etc. (ASTM A182 Gr. F21,F22,F22a; A193 Gr. B16; A213 Gr. T22; A250 Gr. T22; A336 Gr. F21,F22 A356 Gr. 10; A387 Gr. 21,22; A389 Gr. C24; A542 Gr. 2A, 2B; A691 Gr. 12)

Characteristics on Usage

① Wire is a titania type of flux cored wire for all-position welding.
② The weld metal contains about 2.25Cr, 1.0%Mo and has good crack-resistance and heat-resistance.
③ It has excellent creep rupture strength, easy slag removal and good weld soundness.
④ The shielding gas should be used 100%CO_2 for welding.
⑤ Preheat at 200~350℃ and postheat at 690℃.
⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Mo
CO_2	0.05	0.51	1.18	2.25	1.00

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	PWHT
CO_2	630 {64}	680 {69}	24	690℃X1hr.

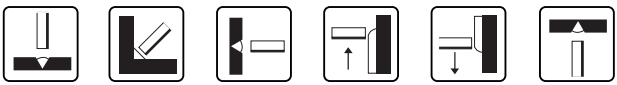
Sizes available and recommended currents (DC wire⊕)

Dia. (mm)		1.2	1.6
Amp.	F	120~340	200~450
	H-Fil		
	V	120~220	180~240

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		

Welding positions



Approved by