



# AUTOMIG FC 91T1-B3

AWS A/SFA 5.29 **E91T1-B3C**

FCAW LOW ALLOY STEEL (High Temperature)

### CLASSIFICATION:

EN ISO 17634-A  
T CrMo2 P C1 2

### KEY FEATURES:

- Rutile type gas shielded FCW wire
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- Low alloy steel Cr-Mo deposit
- Resistant to creep and heat upto 600°C
- Radiographic quality weld

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of 2.25Cr-0.5Mo, 2.25Cr-1Mo type creep resistant steels
- Cr-Mo and Cr-Mo-V bearing steels for high temperature applications
- Main steam pipes of boilers in electric power plant, Boiler super heaters
- Joining of P5A materials
- Joining ASTM A 335 Gr.P22, A 387 Gr.22 materials
- Application in refineries, power plants, pressure vessels, boilers



### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo
0.06	1.0	0.5	2.3	1.0

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 Hr	710	600	19

### PARAMETERS - PACKING DATA:

Ø , mm	Net Wt, Kg	
1.2	15	 <b>DCEP</b> All Positions, Except Vertical Down  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box
1.6	15	

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20