

Need Metal? We get it!

SpecMet CSF-91B3(L)

AWS A5.29 E91T1-B3(L)C - A5.36 E91T1-C1PZ-B3(L)
 KS D 7121 YF2CM-C
 JIS Z 3318 T62T1-1C-2C1M
 EN ISO 17634-A T (CrMo2) P C 1 - ISO 17634-B T62T1-1C-2C1M

Applications

Welding of 2.25%Cr-1.0%Mo Steel used for fire power plant and high pressure boiler, pressure vessel, chemical and oil refining industries etc.

Characteristics

- (1) CSF-91B3(L) is a titania type flux cored wire and designed for all-position welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) It is suitable in welding of low alloy steel of Cr-Mo or carbon steel, high strength steel.
- (4) Used welding grade Ar+CO₂ 20~25% gas.

Notes on Usage

1. Need preheating and interpass temperature control for cold cracking prevention
2. Weld by low heat input to secure good mechanical properties and crack resistance of weld zone

Typical Chemical Composition of Weld Metal (%) (shielding gas: 100% CO₂)

	C	Mn	Si	P	S	Cr	Mo
B3	0.06	0.58	0.64	0.020	0.010	2.30	1.17
B3L	0.03	0.60	0.65	0.019	0.008	2.27	1.15

Typical Mechanical Properties of Weld Metal (%) (shielding gas: 100% CO₂)

	YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL (%)	Heat Treatment
B3L	685	817	17.5	As welded
B3L	580	667	20	690°C x 1 Hr SR

Size and Recommended Current Range (DC+)

Dia (mm)		1.2	1.6
Amp	F & HF	180-340	200-400
Amp	V-Up	120-220	160-260
Amp	V-Down	160-300	200-320
Amp	OH	120-220	160-260