

RAAJCORED-91 B3

An all position rutile type flux cored wire for MAG/MIG welding.

CLASSIFICATION : AWS/SFA-5.29: E91 T1 B3
JIS YF2CM-C

CHARACTERISTICS : Flux-cored wire produce weld metal contain 2.25 Cr- 1.0Mo% for welding high temperatures services and for matching properties of the typical base metals.

APPLICATION : for welding 2.25Cr%-1.1Mo low alloys steels and ASTM A 335-P11 pipe, ASTM A 387 Gr.11 plate.

SHIELDING GAS : Welding with CO₂ gas and Ar+ CO₂ gas mixture.

CHEMICAL COMPOSITION % (Weld Metal Chemistry under CO₂ Gas)

C	Mn	Si	Cr	Mo	S	P
0.060	0.60	0.52	2.50	1.05	0.018	0.020

ALL WELD MECHANICAL PROPERTIES FOR MIG (under CO₂ Gas)

YS (N/mm ²)	UTS (N/mm ²)	EL %	SOAKING HOURS
560-640	620-690	20-26	620°C X 1 hrs.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
1.20	5/ 64"	120-300	24-34	15-25	√	√	√
1.40	1/ 18"	160-340	26-34	15-25	√	√	√
1.60	1/ 16"	180-360	28-36	15-30	√	√	√

Raajratna offer a wide range of Flux-cored welding wires for MIG welding.

Customer packing on request.

www.raajratnaelectrodes.com