

MIDALLOY MASTERCOR E91T1-B3C, B3M FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.29 Class E91T1-B3C, B3M / ASME SFA 5.29 Class E91T1-B3C, B3M

DESCRIPTION

- MIDALLOY E91T1-B3C, B3M flux-cored wire is an “out of position” flux-cored wire, particularly suited for pipe welding.
- This wire can be used for single or multiple pass welding.

APPLICATION

- For welding applications which join low alloy steels to the 2¼ Cr – 1 Mo, ½ Cr, ½ Mo, ¼ V, and other similar chemistries.
- Common materials include ASTM A387 Grade D, (cast) A217.

TYPICAL CHEMISTRY (CO₂ GAS USED)

C	Mn	Si	P	S	Cr	Mo
.055	.55	.54	.015	.015	2.21	1.10

STRESS RELIEVED 1 HOUR @1275°F

TYPICAL MECHANICAL PROPERTIES	100% CO ₂	75%AR/25%CO ₂
	YIELD STRENGTH	86,300 PSI
TENSILE STRENGTH	95,400 PSI	105,300 PSI
% ELONGATION IN 2"	20%	19%

WELDING PARAMETERS

- For .045" diameter with shielding gas CO₂ or Ar mixes up to 75% Ar.

FLAT		VERTICAL UP		OVERHEAD	
VOLTS	AMPS	VOLTS	AMPS	VOLTS	AMPS
23-30	150-290	22-26	150-250	23-26	150-250

STANDARD PACKAGING

- 33 lb. spool

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