

AUTOMIG FC 91T1-B3*

Classification

AWSA/SFA 5.29
E91T1-B3C

Flux Type

Rutile-Neutral

Characteristics

A folded flux-cored wire containing rutile flux, producing radiographic quality sound weld with good arc stability & easy slag detachability.

Typical Applications

Best recommended for joining creep resistant Cr & Mo alloy plate & pipe steels with operating temperatures up to 600°C. Suitable for joining steels conforming to the specification: Grade F22 (class 1 & 3 - P No. 5A) of SA182/SA182M and SA336/SA336M • Grade T4, T22 (P. No. 5A) of SA199/SA199M • Grade T22 (P. No. 5A) of SA-213/SA213M • Grade WC9 (P. No. 5A) of SA-217/217M • Grade P22 (P. No. 5A) of SA-335/SA-335M • Grade FP22 (P. No.5A) of SA-369/SA-369M • Grade 22, 22L (P.No. 5A) of SA387/SA387M • Grade CP22 (P. No. 5A) of SA-426/SA-426M • Grade 22 (class 3P, No. 5C) of SA541/SA-541M Class 1 of A, B type (P. No. 5C) of SA-542/ SA542M

Shielding Gas: CO₂

10-15 litres/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

C	Mn	Si	Cr	Mo	S	P
0.05 - 0.12	1.25 max	0.25-0.55	2.00 -2.50	0.90 - 1.20	0.030 max	0.030 max

Diffusible H₂ content <5 ml/100gms of weld metal

All Weld Metal Mechanical Properties:

Condition	UTS	YS	% Elongation
	MPa	MPa	(L=4×d)
PWHT: 690° C ~1 hr	620 -760	540 min	17 min

Chemical & mechanical properties given above are with A5.32 SG-C gas (100% CO₂)

The chemistry and mechanical properties of the weld will vary with the type of shielding gas.

Welding Positions

F, H, V-up & OH

Packing Specifications

Dia., mm	1.2	1.6
Plastic Spools, net wt Kg	15	15

* Formerly known as - AUTOMIG FC 370



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com

