

# SC-91B3

TYPE : Rutile

AWS A5.29/ ASME SFA5.29 E91T1-B3C  
EN ISO 17634-A-T CrMo2 P C 2

## Applications

SC-91B3 can be used for welding of 2.25%Cr-1.0%Mo steel used for super heat tubes and steam pipes of boilers for electric power plant and marine use, equipment for oil refining industries and high temperature synthetic chemical industries.

## Characteristics on Usage

SC-91B3 is a titania type flux cored wire for all position welding. Arc stability is excellent. Spatter loss is low and slag covering is uniform with good removability.

## Notes on Usage

- ① Use 100% CO<sub>2</sub> gas.
- ② All position gas shielded flux cored wire.

## Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

## Current

DC +

## Shielding Gas

CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.063	0.47	0.83	0.022	0.017	2.32	0.99

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	PWHT
643 (93,300)	730 (106,000)	20	690° C ± 15 × 1Hr

## Approval

## I Packing

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	15
(in)	.045	.052	1/16	(lbs)	33

## Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	250~300	280~350	300~450
V-up & OH	200~260	220~260	240~280
V-Down	250~300	280~350	300~450