

Inweld 91T1-B3

AWS A5.29 E91T1-B3

Chemical Composition of Inweld 91T1-B3

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.05 -0.12	--	2.0-2.5	--	0.9-1.2	1.25	0.8	0.03	0.03	--

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 91T1-B3 is formulated for butt and fillet welding of 2.25%Cr-1.0%Mo steels used for high pressure vessels, oil refining industries, steam pipes of boilers. (ASTM A182 Gr. F21, F22, F22a; A193 Gr. B16; A213 Gr. T22; A250 Gr. T22; A336 Gr. F21, F22 A356 Gr. 10; A387 Gr. 21, 22; A389 Gr. C24; A542 Gr. 2A, 2B; A691 Gr. 12)

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	101,000 psi
Yield Strength:	86,300 psi
Elongation:	23%

Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.045"	120-340	
1/16"	200-450	

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