

SC-91B3

Type : Rutile

Conformances

AWS A5.29/ ASME SFA5.29 E91T1-B3C
EN ISO 17632-A-T CrMo2 P C 2

Applications

- Petrochemical industry
- Pressure vessel

Features

- Stable arc and low spatter level

Welding Position



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

Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

Diameter	Spool
mm (in)	15kg (33lbs)
1.2 (0.045)	√
1.4 (0.052)	√
1.6 (1/16)	√

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 ²)	TS Mpa(lbs/in ²)	EL (%)	PWHT
643 (93,300)	730 (106,000)	20.0	690±15°C X 1Hr

Typical Operating Procedures

Diameter in (mm)	Amp-Volt Range	Typical	Stickout in (mm)
1.2 (0.045) DC+	150 – 260A 24–30V	200A 26V	15 – 25 (5/8 – 1)
1.4 (0.052) DC+	180 – 280A 25–32V	220A 26V	15 – 25 (5/8 – 1)
1.6 (1/16) DC+	200 – 300A 25–32V	240A 27V	15 – 25 (5/8 – 1)

SHAW

SAW

GNIAW

GTAW

FCAW

Non-FERROUS

APPENDIX