

GFC 91B3

LOW ALLOY FLUX CORED WIRE

IDENTIFICATION

GFC 91B3, E91T1-B3C

CLASSIFICATION

AWS/SFA 5.29: E91T1-B3C,
ASME - IIC/SFA-5.29-E 91T1-B3C

DESCRIPTION

Tubular rutile flux-cored wire for single or multipass welding of 2.25 Cr - 1.0 Mo heat resistant steels used for steam pipes of boilers of thermal power plant and similar types of steels, with CO₂ shielding gas. The good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited welds arc of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo
0.05 - 0.12	0.50 - 1.25	0.30 - 0.80	0.030 max	0.030 max	2.0 - 2.50	0.90 - 1.25

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)
630 min	560 min	17 min

After PWHT of 690 ± 14°C/ 1 hour. TYPICAL APPLICATIONS

Power Plant equipment's, pipes and Cr-Mo steels having requirements of high creep resistance.

ALLOYED STEEL : ASTM, A335 Grade P21, P22, F21 or equivalent.

SHIELDING GAS : CO₂ FLOW RATE : 14 - 20 l/min

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	120 - 250	15
1.6	180 - 350	15