

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