

TWE-911B3

AWS A5.29 E91T1-B3C

Characteristics and Applications:

TWE-911B3 is a gas-shielded and all-position flux-cored wire intended for 2.25%Cr-1%Mo low alloy steel welding. It should be used with 100%CO₂ shielding gas and offers good operator appeal. TWE-911B3 is ideal for welding of Cr-Mo steel pipe and Cr-Mo steel, which need high creep resistance.

Notes on usage:

1. Preheat at 200-350°C, and PWHT at 690°Cx1hr.
2. Use DC(+) polarity.
3. Use 99.8% or higher purity of CO₂ Gas.
4. Keep the product dry, while it is stored or delivered.

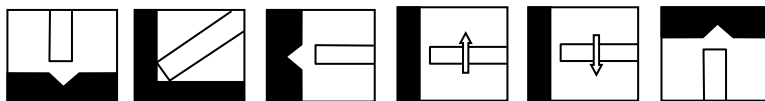
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Mo
AWS	0.05-0.12	≤1.25	≤0.80	≤0.030	≤0.030	2.00-2.50	0.90-1.20
Typical value	0.06	0.50	0.26	0.016	0.011	2.22	1.10

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	PWHT
AWS	≥540(78)	620-760(900-100)	≥17	690±15°Cx1hr
Typical value	645(94)	730(106)	20	690°Cx1hr

Welding position:



Sizes and recommended operating range (DC<+>) :

Stick out:15-25(mm), flow rate:20-25(l/min):

Position	Diameter(mm)	1.2	1.6
	F、HF	180-300A / 26V-36V	180-350A / 26V-38V
VU、OH	150-220A / 24V-28V	160-230A / 24V-28V	

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