



ESSEN TUB 91T1 B3

Classification: AWS A5.29:2010 E91T1-B3 / ASME SFA5.29 E91T1-B3 ED. 25

Rutile flux-cored wire designed for single-pass or multi-pass welding in all positions, recommended for 2.5Cr/1.2Mo cast steels or similar, as well as for boiler steels and heat-resistant tubes, pressure vessels, superheaters, steam generators, and heat exchangers in the oil & gas, petrochemical, and chemical industries.

This wire provides a good deposition rate and a stable arc, allowing for a smooth weld bead finish, low spatter levels, and easy slag removal, ensuring improved efficiency and productivity during operation.

CHEMICAL COMPOSITION:

C	Mn	Si	P	S	Cr	Mo	Cu
0,12% máx.	máx 1,25%	0,35 a 0,8%	0,03% máx	0,03% máx	2,00 a 2,50%	0,9 a 1,2%	0,3 a 0,7%

MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	CHARPY TEST:
620 ~ 760 Mpa	540 Mpa	17% (min)	Not request

SHIELDING GAS:	CURRENT TYPE	STICK-OUT (mm):
100% CO ₂ or 75% Argon / 25% CO ₂ mixture	DC+	15 to 20

PRODUCT FEATURES:

DIAMETER (mm):	CURRENT (A):	VOLTAGE (V):	PACKAGING (kg):
1.20	120 to 280	18 to 30	12.5
1.60	180 to 320	20 to 34	12.5

CUSTOMER SERVICE POLICY

The information provided above is for reference purposes only and shall not be considered as a guarantee or certificate. Many variables may influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA assumes no responsibility for any incorrect application of the product. If you have any questions, we recommend contacting our Technical Assistance Department for proper support.