

Dual Shield 9000-B3

Dual Shield 9000-B3 is an all-position 2.25Cr-1Mo flux cored wire for welding creep resistant steels of similar composition.

Specifications

Classifications	SFA/AWS A5.29 : E91T1-B3C
Welding Current	DC+
Alloy Type	Cr-Mo alloyed
CTOD-Tested	false

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
Stress Relieved	590 MPa	660 MPa	20 %

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
C1 shielding gas				
0.06	0.70	0.40	2.21	1.04

Deposition Data

Diameter	Current	Voltage
1.2 mm	140-330 A	22-34 V
1.6 mm	160-430 A	24-36 V