

# KF91-B3C

Flux Cored wire for  
Heat-Resistant Steel

## Classifications:

AWS A5.29 E91T1-B3C

A5.29M E621T1-B3C

EN ISO 1763 B-T62T-1-1C-2C1M

JIS Z3318 YF2CM-G

## Characteristics and Applications:

KF91-B3C is a rutile-based flux cored wire containing 2.5%Cr-1.0%Mo, for welding 620MPa creep-resistant steels similar composition and intended for services around 600°C, such as A387 Gr. 22 plates and A335 P22 pipes, It can provide stable arc, less spatter and easy slag removal by shielded with CO<sub>2</sub>.

Welding Position: 

## Typical Chemical Composition of All-Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S
AWS	0.05-0.12	1.25	0.80	2.00-2.50	--	0.90-1.20	0.03	0.03
Tested	0.055	0.63	0.32	2.20	0.02	1.00	0.010	0.007

## Mechanical Properties of All-Weld Metal:

Mechanical properties	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
AWS	540	620-760	17
Tested	650	730	20

## Notes on Usage:

- 1.Polarity : DC+.
- 2.Shielding gas : CO<sub>2</sub>.
- 3.Preheat and interpass temperature : 175 ±15°C.
- 4.Heat treatment : PWHT 690±15°C x 1h.

## Sizes Available and Recommended Parameters:

Dia/mm	1.2
Volt	24-32
Amp	150-300
Stick-Out(mm)	15-25
Gas Flow(l/min)	20-25