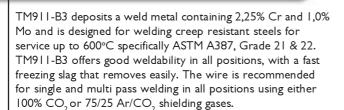
## **PRODUCT DATA SHEET**

# **TM911-B3**





#### **CLASSIFICATION**

**AWS** E91T1-B3M-H8 A5.29

### **CHEMICAL ANALYSIS (TYPICAL)**

	100% CO <sub>2</sub>	75% Ar/25% CO <sub>2</sub>		
% Carbon	0.05	0.05		
% Manganese	0.64	0.92		
% Silicon	0.27	0.38		
% Sulphur	0.013	0.011		

	100% CO <sub>2</sub>	75% Ar/25% CO <sub>2</sub>
% Phosphorous	0.011	0.010
% Molybdenum	0.93	0.97
% Chromium	2.04	2.30

### TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL IN THE AS **WELDED CONDITION)**

	100% CO2	75% Ar/25% CO <sub>2</sub>	
Yield Strength	641 MPa	641 MPa 690 MPa	
Tensile Strength	738 MPa	777 MPa	
Elongation on 5d	20%	18.5%	
Charpy V-Notch	N/R	N/R	

#### **PACKING DATA**

DC+

Diameter (mm)	Volts	Amps	Deposition Rate Kg/Hr	Item Number	Pack Mass (Kg)
	20	115	1.2		
1.2	28	275	to		
Flat & Horizontal	30	325	6.6		
	21	115	1.2	081-146	15 Kg Spool
1.2	26	200	to		
Vertical & Overhead	28	250	4.0		
	21	150	1.8		
1.6	29	350	to		
Flat & Horizontal	31	425	9.2	081-147	15 Kg Spool
	22	150	1.8		
1.6	25	225	to		
Vertical & Overhead	27	275	3.4		

Bold indicates optimum parameters for welder appeal.

Recommended shielding gas: 100% CO2 or Afrox Fluxshield.

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