

TM911-B3



TM911-B3 deposits a weld metal containing 2,25% Cr and 1,0% Mo and is designed for welding creep resistant steels for service up to 600°C specifically ASTM A387, Grade 21 & 22. TM911-B3 offers good weldability in all positions, with a fast freezing slag that removes easily. The wire is recommended for single and multi pass welding in all positions using either 100% CO₂ or 75/25 Ar/CO₂ shielding gases.

CLASSIFICATION

AWS A5.29 E91T1-B3M-H8

CHEMICAL ANALYSIS (TYPICAL)

	100% CO ₂	75% Ar/25% CO ₂		100% CO ₂	75% Ar/25% CO ₂
% Carbon	0.05	0.05	% Phosphorous	0.011	0.010
% Manganese	0.64	0.92	% Molybdenum	0.93	0.97
% Silicon	0.27	0.38	% Chromium	2.04	2.30
% Sulphur	0.013	0.011			

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

	100% CO ₂	75% Ar/25% CO ₂
Yield Strength	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)
1.2 Flat & Horizontal	20	115	1.2	081-146	15 Kg Spool
	28	275	to		
	30	325	6.6		
1.2 Vertical & Overhead	21	115	1.2		
	26	200	to		
	28	250	4.0		
1.6 Flat & Horizontal	21	150	1.8	081-147	15 Kg Spool
	29	350	to		
	31	425	9.2		
1.6 Vertical & Overhead	22	150	1.8		
	25	225	to		
	27	275	3.4		

Bold indicates optimum parameters for welder appeal.

Recommended shielding gas: 100% CO₂ or Afrox Fluxshield.

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