

# Dual Shield 9000-B3(L)

AWS A5.29 E91T1-B3C / JIS Z3318 YF2CM-C

## Description and Application

- Dual Shield 9000-B3 is an all-position flux cored electrode which deposits a 2.25% Cr-1% Mo weld metal. The weld metal analysis is similar to an E9018-B3 low hydrogen electrode. Dual Shield 9000-B3 is recommended for welding 2.25% Cr-1% Mo steels. This wire is designed for single or multiple pass welding. Shielding gas of 100% CO<sub>2</sub> and 75% Ar-remainder CO<sub>2</sub> may be used.

Flux  
CORED  
WIRES

## Shielding Gas : 100%CO<sub>2</sub> or 75%Argon/25%CO<sub>2</sub>

## Typical Mechanical Properties of All Weld Metal

Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)	PWHT
715 {73}	825 {84}	13	As-Welded
590 {60}	660 {67}	20	690 °C × 1hr

## Typical Undiluted Weld Metal Analysis %(100%CO<sub>2</sub>)

구분	C	Mn	Si	Cr	Mo
Dual Shield 9000-B3	0.06	0.70	0.40	2.21	1.04
Dual Shield 9000-B3L	0.03				