Dual Shield T-85-B2

AWS A5.29 E80T5-B2M / JIS Z3318 YF1CM-G

Description

- Dual Shield T-85-B2 is a member of ESAB SeAH family of outstanding small diameter, basic slag, flux cored wires. The basic slag system assures optimum weld quality and resistance to cracking. The small diameters, with their favorable high current density, display deep penetration and high deposition rates.
- When the recommended welding parameters and shielding gas are used, a very smooth low spatter, spray-type arc is attained. The deposited weld metal achieves as welded and stress relieved properties equal to or better than the corresponding low hydrogen electrodes.

Shielding Gas : 75%Argon/25%CO_2

Application

- To obtain a smooth spray transfer, minimal spatter and good wetting action, a mixture of 75%Argon/25%CO_2 shielding gas is recommended.
- Dual Shield T-85-B2 is engineered for single and multi-pass welds in the flat and horizontal positions. It is alloyed to weld the chrome-moly steels in the categories of 1/2Cr-1/2Mo, 1Cr-1/2Mo. and 1 · 1/4Cr-1/2Mo.

Typical Mechanical Properties of All Weld Metal (All weld Metal Using 75% Argon/25% CO_2)

Yield Point N/mm²{kgf/mm²}	Tensile Strength N/mm²{kgf/mm²}	Elongation (%)	Impact Value J(kgf · m)		PWHT
			-20℃	-46℃	
600 {61}	710 {72}	23	77 {7.9}	52 {5.3}	As-Welded
530 {54}	634 {65}	24	121 {12.3}	78 {8.0}	690℃×2hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Cr	Mo
0.07	0.86	0.49	0.014	0.012	1.15	0.53