

Dual Shield T-95-B3

AWS A5.29 E90T5-B3M / JIS Z3318 YF2CM-G

Flux
CORED
WIRES

Description

- Dual Shield T-95-B3 joins the ESAB SeAH family of outstanding small diameter, basic slag, flux cored electrodes. Optimum weld quality and resistance to cracking are assured with the basic slag system. The high current density capabilities of the small diameters promotes deep penetration and high deposition rates.
- With the recommended shielding mixture and welding parameters, a very smooth, minimum spatter, spray-type arc is realized.

Shielding Gas : 75%Ar/25%CO₂

Application

- To obtain the excellent arc characteristics and to retain the physical properties, a mixture of 75%Argon/25%CO₂ is recommended.
- Dual Shield T-95-B3 is designed for single and multi-pass welding in the flat position and for horizontal fillets. It is formulated to weld the 2 · 1/4 Cr-1 Mo steels.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)		PWHT
			0°C	-20°C	
730 {63}	854 {87}	20	34 {3.5}	22 {2.2}	As-Welded
565 {58}	676 {69}	22	75 {7.7}	42 {4.3}	690°C x1hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Cr	Mo
0.07	0.90	0.54	0.015	0.012	2.32	1.05