

Flux Cored Wires for Cr-Mo Creep-Resisting Steels

DW 81B2 & DW 91B3

General information

DW 81B2 and DW 91B3 are two flux cored wires developed for welding 1,25%Cr-0,5%Mo and 2,25%Cr-1,0%Mo steels respectively. These wires are characterised by a fine spray arc transfer, low spatter levels, flat to slightly convex bead shape and self-releasing slag.

Advantages

- Higher productivity then with MMA
- Fully positional in spray mode without having to use a synergic pulsed MIG equipment
- Fully positional without the risk of lack of fusion defects sometimes associated with solid wire MIG
- Better slag detachability then with MMA

Details

Flux type:	Rutile
Wire diameter:	1,2 mm
Welding position:	All-position
Shielding gas:	80%Ar-20%CO ₂ (M21) or 100%CO ₂ (C1)
Classification:	DW 81B2 AWS A5.29 E81T1-B2M, B2 DW 91B3 AWS A5.29 E91T1-B3M, B3

Spool box: Kobelco





Product News

Properties

Typical chemical composition of all weld metal (wt%)

Wire	C	Si	Mn	P	S	Cr	Mo
DW-81B2	0,06	0,61	0,62	0,009	0,011	1,29	0,50
DW-91B3	0,05	0,62	0,59	0,008	0,010	2,25	0,97

Typical mechanical properties of all weld metal

Wire	PWHT	Rp0,2% (N/mm ²)	Rm (N/mm ²)	A (%)
DW-81B2	690°C x 1hr	587	678	25
DW-91B3	690°C x 1hr	633	723	21

Availability

Stock: 1 pallet / product

LT: from stock within one week

Product code

DW 81B2: 95932012

DW 91B3: 95942012

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