

# PRODUCT DATA SHEET

## Trimark 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 and 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% CO<sub>2</sub> or 75/25 Ar/CO<sub>2</sub> shielding gases.

### Classifications

AWS	A5.29	E91T1-B3M-H8
EN	17634-A	T CrMo 2 PM2 H5
EN	17634-B	T62 T1-1M-2C1M-H5

### Typical Chemical Analysis

	100% CO <sub>2</sub>	75% Ar/25% CO <sub>2</sub>		100% CO <sub>2</sub>	75% Ar/25% CO <sub>2</sub>
% Carbon	0,05	0,05	% Phosphorous	0,011	0,01
% Manganese	0,64	0,92	% Molybdenum	0,93	0,97
% Silicon	0,27	0,38	% Chromium	2,04	2,3
% Sulphur	0,013	0,011			

### Typical Mechanical Properties (All weld metal in the as welded condition)

	100% CO <sub>2</sub>	75% Ar/25% CO <sub>2</sub>
Yield Strength	641 MPa	690 MPa
Tensile Strength	738 MPa	777 MPa
% Elongation on 5d	20	18,5
Charpy V-Notch	N/A	N/A

### Packing Data (DC+)

Diameter (mm)	Current		Deposition Rate (kg/hr)	Pack Mass (kg)	Item Number
	Volts (V)	Amps (A)			
1,2 Flat & Horizontal	20	115	1,2 to 6,6	15,0 (spool)	W081146
	<b>28</b>	<b>275</b>			
	30	325			
1,2 Vertical & Overhead	21	115	1,2 to 4,0	15,0 (spool)	W081147
	<b>26</b>	<b>200</b>			
	28	250			
1,6 Flat & Horizontal	21	150	1,8 to 9,2	15,0 (spool)	W081147
	<b>29</b>	<b>350</b>			
	31	425			
1,6 Vertical & Overhead	22	150	1,8 to 3,4	15,0 (spool)	W081147
	<b>25</b>	<b>225</b>			
	27	275			

Bold indicates optimum parameters for welder appeal.  
Suggested shielding gas: 100% CO<sub>2</sub> or Afrox Fluxshield®

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02  
E-mail: customer.service@afrox.linde.com Website: [www.afrox.com](http://www.afrox.com)

