

Dual Shield II 91-H4

FCAW wire for 670N/mm² class high tensile strength steel. Dual Shield II 91-H4 is an all-position wire developed to meet the tests for hydrogen levels of less than 4ml/100g of weld metal. This designed for high mechanical properties and low temperature impact toughness. It is intended for use on EH50, 55, EQ 56 and others of which Min. Y.S 550Mpa.

Specifications

Classifications	SFA/AWS A5.29 : E91T1-K2C SFA/AWS A5.36 : E91T1-C1A2-K2 JIS Z 3313 : T624T1-1CA-N3M1
Approvals	ABS : 4YQ550SA, H5 BV : SA4Y55,H5 CCS : 4Y55,S,H5 DNV : IV Y55MS(H5) LR : 4Y55, H5

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	C Mn Ni
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding Gas			
As Welded	590 MPa	690 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding Gas		
As Welded	-40 °C	80 J
As Welded	-30 °C	95 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
C1 Shielding Gas			
0.040	1.40	0.30	1.64