

Dual Shield II 91-LT

FCAW wire for 550N/mm² , 620N/mm² class high tensile steel for low temperature service. Dual Shield II 91- LT is a high strength all position flux cored electrode designed to provide satisfactory low temperature impact toughness down to -60°C and good CTOD value at -40°C.

Specifications	
Classifications	SFA/AWS A5.29 : E91T1-Ni2C
Approvals	ABS : 5YQ500SA H5 BV : 5Y50SA, H5 DNV : VY50 (H5) GL : 6Y50H5S LR : 5Y50S, H5

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

Welding Current	DC+
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding Gas			
As Welded	575 MPa	650 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
C1 shielding Gas		
As Welded	-40 °C	100 J
As Welded	-60 °C	85 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
0.05	1.38	0.30	2.20