

Pipeweld 91T-1

An all-positional rutile cored wire for pipe welding of steels with a minimum strength of 550 MPa, for use with M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E91T1-G EN ISO 18276-A : T 55 4 Z P M21 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479

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

Welding Current	DC+
Alloy Type	Low alloy

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	604 MPa	670 MPa	27 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
As Welded	-40 °C	95 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Mo
0.05	1.25	0.37	0.93	0.12

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h