

Dual Shield B6

Dual Shield B6 is an all-position flux cored electrode designed for using with 75% Ar / 25% CO₂ or 100% CO₂ shielding gas. Dual Shield B6 is intended for use on pipe and plate steels having a nominal 5% chromium - 0.5% molybdenum composition. These steels are typically used in process piping in the oil, gas, petrochemical, and marine industries.

Specifications

Classifications	SFA/AWS A5.29 : E81T1-B6C SFA/AWS A5.29 : E81T1-B6M
Industry	Pipeline Petrochemical Power Generation

Alloy Type	Low Alloy 5% Cr, 0.5% Mo
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding Gas			
Stress Relieved 2 hour(s) 746 °C (1375 °F)	580 MPa (84 ksi)	676 MPa (98 ksi)	20 %
C1 Shielding Gas			
Stress Relieved 2 hour(s) 746 °C (1375 °F)	540 MPa (78 ksi)	640 MPa (93 ksi)	20 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo
0.08	0.60	0.50	0.006	0.01	4.70	0.50

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	150-310 A	28-34 V	5.08-15.24 m/min (200-600 in./min)	1.91-5.31 kg/h (4.2-11.7 lbs/h)