



FLUX CORE WIRES FOR HEAT-RESISTING STEEL

Brand Name	Size (mm)	Equivalent Specification	Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)										Typical Mechanical Properties of All-Weld Metal				Characteristics and Applications	Approvals
						C	Si	Mn	P	S	Cr	Mo	PV	Y.S (MPa)	T.S (MPa)	El.(%)	PWHT Condition				
K-81TA1	1.2~1.6	AWS A 5.29 JIS Z 3318 KS D 7121 EN ISO 17634-A EN ISO 17634-B	E81T1-A1C YFM-C YFM-C T (Mo) P C 1 T55 Z T1-1C-2M3	F,V,OH, H,VD	CO ₂	DC(+)	0.02	0.55	1.21	0.010	0.010	-	0.53	-	531	610	25	620°C×1hr. S.R.	Single- and multi-pass welding in all position using 100%CO ₂ shielding gas steam pipes of boilers, oil refining industries, casting and pressure vessels for high temperature service.	CE	
K-81TB2L	1.2~1.6	AWS A 5.29 JIS Z 3318 KS D 7121 EN ISO 17634-A EN ISO 17634-B	E81T1-B2LC YF1CM-C YF1CM-C T(CrMo 1L)PC1 T55 Z T1-1C-1CML	F,V,OH, H,VD	CO ₂	DC(+)	0.03	0.43	1.10	0.010	0.010	1.28	0.56	-	531	660	25	690°C×1hr. S.R.	For welding of 1.25%Cr-0.5%Mo steel for main steam pipes of boilers for electric power and equipment oil refining industries and high temperature synthetic industries.	CE	
K-81TB2	1.2~1.6	AWS A 5.29 JIS Z 3318 KS D 7121 EN ISO 17634-A EN ISO 17634-B	E81T1-B2C YF1CM-C YF1CM-C T (CrMo 1) P C 1 T55 Z T1-1C-1CM	F,V,OH, H,VD	CO ₂	DC(+)	0.07	0.42	1.00	0.020	0.010	1.21	0.48	-	572	637	24	690°C×1hr. S.R.	For welding of 1.25%Cr-0.5%Mo steel for main steam pipes of boilers for electric power and equipment oil refining industries and high temperature synthetic industries.	CE	
K-91TB3L	1.2~1.6	AWS A 5.29 JIS Z 3318 KS D 7121 EN ISO 17634-A EN ISO 17634-B	E91T1-B3LC YF2CM-C YF2CM-C T(CrMo 2L)PC1 T62 Z T1-1C-2C1ML	F,V,OH, H,VD	CO ₂	DC(+)	0.03	0.51	1.20	0.010	0.010	2.25	1.03	-	630	680	25	690°C×1hr. S.R.	For welding of 2.25%Cr-1%Mo steel used for steam pipes of boilers, oil refining industry casting and pressure vessels for high temperature service.	CE	
K-91TB3	1.2~1.6	AWS A 5.29 JIS Z 3318 KS D 7121 EN ISO 17634-A EN ISO 17634-B	E91T1-B3C YF2CM-C YF2CM-C T(CrMo 2)PC1 T62 Z T1-1C-2C1M	F,V,OH, H,VD	CO ₂	DC(+)	0.06	0.50	1.00	0.020	0.010	2.27	1.00	-	629	703	23	690°C×1hr. S.R.	For welding of 2.25%Cr-1%Mo steel used for steam pipes of boilers, oil refining industry casting and pressure vessels for high temperature service.	CE	
K-91TB3LS	1.2~1.6	AWS A 5.29	E91T1-G	F,V,OH, H,VD	CO ₂	DC(+)	0.03	0.46	1.03	0.140	0.014	2.22	0.97	0.23	710	760	20	664°C×4hr. S.R.	For welding of 2.25%Cr-1%Mo-V-Nb steel used for steam pipes of boilers, oil refining industry casting and pressure vessels for high temperature service.	-	
K-91TB9	1.2~1.6	AWS A 5.29 EN ISO 17634-B	E91T1-B9M T69T1-1M-9C1MV	F,V,OH, H,VD	Ar+20%C O ₂	DC(+)	0.09	0.31	0.70	0.010	0.015	9.06	1.10	0.73	641	723	20	760°C×2hr. S.R.	Butt and fillet welding of 9%Cr-1%Mo-Ni-Nb-V steel used for high pressure boilers. Applications are ASTM A189-F91, A199-T91, A231-T91, A369-FP91, A387-Gr91	-	

Brand Name	Size (mm)	Equivalent Specification	Welding Position	Shielding Gas	Type of Current	Typical Chemical Composition of All-Weld Metal (%)								Typical Mechanical Properties of All-Weld Metal				Characteristics and Applications	Approvals
						C	Si	Mn	P	S	Cr	Mo	PV	Y.S (MPa)	T.S (MPa)	El.(%)	PWHT Condition		
K-101TB9	1.2~1.6	-	F,V,OH, H,VD	Ar+20%C O ₂	DC(+)	0.12	0.26	0.72	-	-	9.6	1.00	-	720	810	18	760°C×2hr. S.R.	It is designed for welding of 700MPa 9%Cr-1%Mo-V steels used for high pressure boilers, chemical and oil refinery plants.	-



NOCKERS
ENGINEERING PRODUCTS