Revishield® 91T8

Self-shielded cored wire

Classification

AWS A5.29/A5.29M :E91T8-G

General description

Self shielded: easiest equipment arrangement
Semi-automatic fill and cap pass welding of X-80 pipe steel in vertical down position
Excellent low temperature toughness
Low hydrogen H_{DM}< 8 ml/100 gr

Welding positions

ISO/ASME PG/5G down

Current type / Shielding gases

DC -

Approvals

TÜV
+

Typical chemical composition of all weld metal, (w%)

C	Mn	Si	P	S	Al	Ni
0.05	1.65	0.25	0.007	<0.003	0.85	0.8

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J -30°C
Required	AWS A5.29			min 540	620-760	17	
Typical values after welding			AW(1G)	585	650	26	115

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.7	2.0
Coils 14C	6.35	X	X

Identification Imprint: Revishield®91T8

Revishield®91T8: rev. EN 20

Suggestions for use

Preheat and interpass temperature depending on steel quality
For root pass welding of X-60 to X-80 the Revishield® 71T-GS electrode is recommended

Materials to be welded

Steel	Code	Type
Pipe material	API 5LX	X-60 to X-80
	EN 10208-2	L415, L445, L480, L550

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed cm/min	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
1.7	19	150	145	15.5	1.0	
		205	180	17.5	1.3	
		270	215	18.5	1.8	
		370	255	20.5	2.4	