# BÖHLER PIPESHIELD 91 T8-FD

Self-shielded flux-cored wire, low-alloyed

## Classifications

| EN ISO 18276-A | EN ISO 18276-B | AWS A5.29 / SFA-5.29 |
|---|---|---|
| T55 3 ZMn2.5Ni Z NO 1 H10 | T62 3 T8-1 NO A-GN3M2-U H10 | E91T8-G |

## Characteristics and typical fields of application

Böhler Pipeshield 91 T8-FD is a self-shielded flux-cored wire especially developed for vertical down welding of filler and cap layers in pipeline applications. It is also suitable for welding of low alloyed steel constructions. The wire offers excellent welding characteristics with high productivity. It has a fast freezing, easily removable slag system.
The weld metal shows excellent mechanical properties and superior impact toughness at low temperatures.
Due to the fluoride-basic filling, the recommended interpass temperature is 80 – 200ºC.

## Base materials

Acc. to API 5L:
X65, X70, X80

## Typical analysis

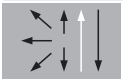
| | C | Si | Mn | Ni | Al |
|---|---|---|---|---|---|
| wt.-% | 0.04 | 0.25 | 2.0 | 3.0 | 0.8 |

## Mechanical properties of all-weld metal - typical values (min. values)

| Condition | Yield strength $R_e$ | Tensile strength $R_m$ | Elongation A ($L_0=5d_0$) | Impact energy ISO-V KV J | | |
|---|---|---|---|---|---|---|
| | MPa | MPa | % | 20 °C | -30 °C | -40 °C |
| u | 600 (≥ 550) | 680 (620 – 820) | 23 (≥ 18) | 155 | 120 (≥47) | 100 |

u untreated, as welded - without shielding gas

## Operating data



| | |
|---|---|
| **Polarity** | DC – |
| **Shielding gas (EN ISO 14175)** | NO GAS |
| **Stick-Out** | 10 – 25 mm |

| Dimension mm |
|---|
| 1.4 |
| 2.0 |

Recommended stick out: 10 – 25 mm

## Approvals

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