DevTek 91 SR+

Flux Cored Wire for 4130 Steel

AWS A5.29 – E91T1-G, ASME SFA: A5.29 – E91T1-G

Typical Applications:

- Designed for joining and repair of AISI 4130, 8630, 8630 Modified and Q&T steels that require PWHT
- Oilfield equipment – BOP, Subsea Components
- Alloy Forging and Casting Repair
- Stamping dies and equipment

Product Advantages:

- High yield and tensile strength after PWHT
- Hardness <250 HV10
- Flat bead with easy slag release
- Excellent Toughness
- Operates on both mixed gas and pure CO_2

Typical Mechanical Properties					
	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs)@-25F	HV10
SR 2 hr @1175°F	96	82	25	45	220
SR 12 hr @1175°F	93	78	25	50	218
SR 26 hr @1175°F	91	79	25	57	-

Deposit Composition Range							
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
DevTek 91 SR+	0.05 – 0.10	1.0 – 1.5	0.5 max	<1.0	0.5 max	0.5 max	0.5 max

Available Diameters: 0.045” (Additional sizes may be available upon request)

Typical Welding Parameters				
Diameter	Amperage Range	Voltage Range	Gas	Current
0.045”	175 – 250	25 – 28	75% Ar / 25% CO_2	DCEP
1/16”	245 – 275	26 – 29	75% Ar / 25% CO_2	DCEP

Packaging: The product is packaged on 25 or 50lb. spools with a vapor corrosion inhibitor strip, vacuum-packaged and placed in a specially designed carton for long term storage.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec**. Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.
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