



FCW 61-B

High temperature basic cored wire

Classification

AWS A5.36 : E80T5-M21P8-A1-H4 ISO 17632-A T 46 6 Mo B M 3 H5
 ISO 17632-B T556T5-0M-2M3-H5

Description & Applications

Seamless Basic cored tubular wire 0.5%Mo Steel steel for semi- and automatic gas shielded arc welding. Designed to welded creep resisting steels used at temperatures up to 500°C. Good resistance to hydrogen attack

Main applications: Cranes, vessel and apparatus construction

Base material:

High strength steels

EN- Designation	16Mo3 – 18MnMo4 S235JR – S355JR	P195 – P265 L245MB-L450MB
ASTM	A29 Gr1016 A204 GrA – A 155 Gr CM	A335 GrP1 – A352 GrLC1

Typical Chemical Composition (%)

C	Mn	Si	P	S	Mo	Fe
0.08	1.00	0.35	0.015	0.015	0.50	Rem.

Typical All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
520	600	24	+20°C	210
			-40°C	150

Value as welded with M21 shielding gas

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current(A)	Voltage (V)	Stick-out (mm)	
MIG = +	1.2 1.6	-	-	12-25 15-25	ISO 14175 : M21 (Ar/CO ₂) 12-15 l/min

A final PWHT should be carried out at 560-650°C during 1 hour minimum

FT En-C0xxx-1503

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