



# FCW 63-R

Flux cored wire for creep resistant steel

## Classification

AWS A5.29 : E81T1-B2M H4      ISO 17634-A      T CrMo1 P M 1 H5

## Description & Applications

Copper coated flux cored wire for gas shielded arc welding creep resistant steel with Ar-CO<sub>2</sub> mix gas. The fast freezing and easy remove slag is designed to weld in all positions.

**Main applications:** petrochemical industry, chemical industry.

### Base materials:

### Steels and pipes for boiler and pressure vessels:

NF A 36-206	:	15D3 - 18MD4 -05 -15CD2.05 - 15 CD4.05
DIN 17155	:	13 CrMo 4.4 - 15CrMo3 - 13CrMoV42
DIN 1681	:	GS 22 CrMo5.4 – GS 22 Mo4
ASTM	:	A537 - A299 A355 GrP11 u. P12

### Heat treatable steels:

NF A 35-551	:	18CD4 - 16CM5
NF A 35-552	:	25CD4
DIN 17210	:	25CrMo4

## Typical Chemical Composition ( % )

C	Mn	Si	P	S	Cr	Mo	Fe
0.05	0.80	0.50	< 0.025	< 0.025	1.30	0.50	Rem.

## Typical All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
> 470	550 – 690	20	+20°C      60

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current(A)	Voltage (V)	Stick-out (mm)	
= +	1.2	190-320	22-35	12-25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 12 - 20 l/min
	1.6	210-380	23-37	12-25	



FT En-C048BR-1410

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