

## Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.29 / SFA-5.29
T 55 4 1NiMo B M21 3 H5	T 62 4 T5-0M21A-N2M2-UH5	E90T5-GM-H4

## Characteristics and typical fields of application

Seamless basic flux-cored wire for welding of high strength Nickel-Molybdenum alloyed steels with Ar-CO<sub>2</sub> shielding gas. Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, very low spatter losses, easy to remove slag, exceptional mechanical properties at low temperatures with low content of diffusible hydrogen in the weld metal (< 3ml/100g).

## Base materials

S420N-S460N, S420M-S460M, S460Q-S555Q, S460QL-S550QL, P460N,P460NH, L415NB, L415MB-L555MB, L415QB-L555QB, PAS 460-550, alform 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL, 20MnMoNi4-5, 15NiCuMoNb5-6-4  
ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X60, X65, X70, X80, X60Q, X65Q, X70Q, X80Q

## Typical analysis

	Gas	C	Si	Mn	Ni	Mo
wt.-%	M21	0.05	0.35	1.40	1.20	0.40

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

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J
	MPa	MPa	%	-40°C
u	590 (≥ 550)	670 (640–760)	22 (≥ 18)	100 (≥ 47)

u - untreated, as welded – shielding gas M21

## Operating data

	<b>Polarity</b>	DC+	<b>Dimension mm</b>
	<b>Shielding gas (EN ISO 14175)</b>	M21	1.2

Welding with conventional or pulsed power sources using DC+

## Approvals

CE