

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.28 / SFA-5.28
T CrMo2 M M21 1 H5	T 62 T15-1M21-2C1M-H5	E90C-B3H4

Characteristics and typical fields of application

Seamless, Cr-Mo alloyed, metalcored wire for singleor multilayer welding of creep resistant steels up to 600°C with Ar-CO₂ shielding gas. Features include: high yield, good weldability, excellent bead appearance, very low spatter losses. Wire with very low amount of diffusible hydrogen (< 3ml/100g) that reduces the risk of cracks.

Base materials

10CrMo9-10, 10CrMo11, 16CrMo9-3, 11CrMo9-10, 26CrMo7, G17CrMo9-10, G19CrMo9-10, ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; A 335 Gr. P22; A 336 Gr. F22; A 426 CP22;

Typical analysis

	Gas	C	Si	Mn	Cr	Mo
wt.-%	M21	0.06	0.35	1.10	2.20	1.00

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

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-10°C
s	550 (≥ 540)	740 (620–760)	23 (≥ 18)	110 (≥ 47)	90

s stress relieved 700°C / 60min – shielding gas M21

Operating data

	Polarity	DC +	Dimension mm
	Shielding gas (EN ISO 14175)	M21	1.2
			1.6

Welding with standard GMAW power source with DC+ polarity.

Approvals

TÜV (07159), CE