

## Classifications

<b>EN ISO 17634-A</b>	<b>EN ISO 17634-B</b>	<b>AWS A5.29 / SFA-5.29</b>
T CrMo5 B M21 3 H5	T 55 T5-0M21-5CM-H5	E80T5-B6M-H4

## Characteristics and typical fields of application

Seamless basic flux-cored wire for welding of alloyed steels creep resistant and containing 5.00% Chromium and 0.50% Molybdenum with Ar-CO<sub>2</sub> shielding gas.

Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, low spatter, easy to remove slag, good mechanical properties and depositions with very low contents of diffusible hydrogen (< 3ml/100g).

## Base materials

X12CrMo5, GX12CrMo5  
ASTM A 213 Gr. T5, A 335 Gr. P5

## Typical analysis

	Gas	C	Si	Mn	Cr	Mo
wt.-%	M21	0.07	0.45	1.10	5.00	0.50

## 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	%	20°C
s	490 (≥ 470)	600 (550–690)	19 (≥ 17)	100 (≥ 47)

s stress relieved 745°C / 60min – 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 standard GMAW power source with DC+ polarity.

## Approvals

CE