

## Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.29 / SFA-5.29
T CrMo1 B M21 3 H5	T 55 T5-0M21-1CM-H5	E80T5-B2M-H4

## Characteristics and typical fields of application

Seamless basic flux-cored wire for welding of Chromium-Molybdenum alloyed creep resistant steels with an application temperature up to 500°C with Ar-CO<sub>2</sub> shielding gas.

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

## Base materials

1.7335 13CrMo4-5, 1.7262 15CrMo5, 1.7728 16CrMoV4, 1.7218 25CrMo4, 1.7225 42CrMo4, 1.7258 24CrMo5, 1.7354 G22CrMo5-4, 1.7357 G17CrMo5-5; ASTM A 182 Gr. F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12;

## Typical analysis

	Gas	C	Si	Mn	Cr	Mo
wt.-%	M21	0.06	0.45	1.10	1.20	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)	590 (550–690)	24 (≥ 20)	100 (≥ 47)
s stress relieved 690°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
			1.6

Preheat, interpass temperature and post weld heat treatment as required by the base metal.

## Approvals

CE