

## Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.28 / SFA-5.28
T CrMo1 M M21 1 H5	T 55 T15-1M21-1CM-H5	E80C-B2H4

## Characteristics and typical fields of application

Seamless, Cr-Mo alloyed, metalcored wire for singleor multilayer welding of creep resistant steels up to 500°C with Ar-CO<sub>2</sub> 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

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	0.40	1.10	1.20	0.50

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

Condition	Yield strength	Tensile strength	Elongation A	Impact energy ISO-V KV J		
	R <sub>p0.2</sub>	R <sub>m</sub>	(L <sub>0</sub> =5d <sub>0</sub> )	20°C	-10°C	-20°C
	MPa	MPa	%			
s	520 (≥ 470)	620 (550–690)	22 (≥ 20)	110 (≥ 47)	90	80

s stress relieved 690°C / 60min – shielding gas M21

## Operating data

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

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

## Approvals

TÜV (07158), DB (42.052.16), CE