

**Standards**

TS EN ISO 17632-A	: T 46 2 Mo M M 3
EN ISO 17632-A	: T 46 2 Mo M M 3
EN ISO 17634-A	: T MoL M M 3
AWS A5.29	: E80T1 – A1 M

**Chemical Composition of  
Weld Metal (Typical)**

Si	C	Mn	Mo
0.06	0.03	1.20	0.50

**Mechanical Properties - (Typical)**

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-20°C)	Impact Strength (ISO-V/0°C)	Impact Strength (ISO-V/+20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
SR	min. 470	550 - 680	min. 47	147	162	min. 20
AW	min. 470	550 - 680	min. 47	102	158	min. 20

SR: Stress Relieved (620 °C/1h furnace down to 300 °C / air), AW: As welded

**Typical Base Material Grades**

- DIN: H1, H11, 17Mn4, 19Mn5, 15Mo3, 16Mo3,
- EN: P 235 GH, P 265 GH, P 295 GH, 16 Mo 3, P 235 T1/T2-P355 N, L210-L485, S255-L460
- ASTM: A 161, A 204, A 302, Gr A plate, A335-P1 pipe

**Features and Applications**

- Metal type flux-cored wire which provides a smooth arc, low spatter and good weldability.
- This type of electrode is commonly used in the fabrication and erection of boilers and pressure vessels.
- Typical applications include the welding of C-Mo steel base metals such as ASTM.
- High efficiency type for economic production environments and Mo-steels up to 500 °C.
- Metal cored wire without slag primarily used with Argon/Carbon Dioxide shielding gas mixtures in the flat and horizontal-vertical positions, however, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.
- Fast freezing characteristics facilitate butt and fillet welding.
- Shielding gas: M21

**Welding Positions**

**Current Type**

FCAW D.C (+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500386	Ø1.2	Ø3/64	15	D 320

Approvals: SEPRO, CE