

### Standards

TS EN ISO 17634-A	: T CrMo1 R C 2
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AWS A5.29	: E81 T1-B2C

### Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Mo
0.06	0.50	1.20	1.20	0.50

### Mechanical Properties - (Typical): (With M21 gas)

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (RT)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
680°C / 1h	min. 460	550 - 690	min. 80 J	min. 19
920°C / 30 min.	min. 320	450 - 550	min. 100 J	min. 26

RT: room temperature

### Typical Base Material Grades

- DIN: 13 CrMo 44, 24 CrMo 5
- Cast Steels: GS 17CrMo55, GS 22CrMo54, G17CrMo5-5, G22CrMo5-4
- EN: 13 CrMo 4-5, G 17 CrMo 5-5, G 22 CrMo 5-4
- ASTM: A 182, A 387, A217, A 387 Gr. 11-12

### Features and Applications

- Rutile type flux-cored wire
- Typical applications are vessel and steel construction, mechanical engineering and pipe work
- Good arc restriking even with cold wire tip, suitable for robot applications
- Multi-pass welding without in-between cleaning
- Ideal for use in the field short arc and spray arc
- Excellent gap bridging for root welding
- High-efficiency type for economic production environments
- Shielding gas: CO<sub>2</sub>

### Welding Positions



### Current Type

D.C (+)

### Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500121	1.20	0.047"	15	BS 300

Approvals: CE, SEPRO