

Standards

TS EN ISO 17634-A	: T CrMo2 R C 1 / T CrMo2 R M 1
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AWS A5.29	: E 91T1 - B3C/B3M

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

C	Si	Mn	Cr	Mo
0.05	0.45	1.00	2.40	1.00

Mechanical Properties - (Typical)

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
690°C / 1h	min. 540	620 - 760	min. 47 J	min. 18

Typical Base Material Grades

- 2.25% Cr - 1% Mo steels such as ASTM A387 or P21/P22 pipes.

Features and Applications

- Rutile type flux cored wire for all position welding
- Excellent weldability for vertical up position (PG) and overhead fillet (PD) position
- Good arc stability and weldability
- Shielding gas: 100% CO₂ or Ar+CO₂ mix

Welding Positions

Current Type

FCAW D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500387	1.20	0.047"	15	BS 300

Approvals: SEPRO, CE