

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.36	AWS A5.36M
T CrMo5 B M 3 H5	T55T5-0M-5CM-H5	E80T5-M21PY-B6-H4	E550T5-M21PY-B6-H4

Characteristics and typical fields of application

Seamless basic flux cored wire for welding of alloyed steels creep resistant and containing 5.00% Chromium and 0.50% Molybdenum with Ar-CO₂ shielding gas.
Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, low spatter, easy to remove slag, good mechanical properties and depositions with very low contents of diffusible hydrogen (< 3ml/100g).

Base materials

X12CrMo5, GX12CrMo5
ASTM A 213 Gr. T5, A 335 Gr. P5

Typical analysis of all-weld metal (wt.-%)

	Gas	C	Si	Mn	Cr	Mo
wt-%	M21	0.07	0.45	1.10	5.00	0.50

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20°C
s	490 (≥470)	600 (550–690)	19 (≥17)	100 (≥47)

s stress relieved 745°C / 60min – shielding gas M21

Operating data

	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M21	ø (mm)
			1.2
			1.4
			1.6

Welding with standard GMAW-facilities possible

Approvals

CE