

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.36	AWS A5.36M
T CrMo2 M M 1 H5	T62T15-1M-2C1M-H5	E90T15-M21PY-B3-H4	E620T15-M21PY-B3-H4

Characteristics and typical fields of application

Seamless, Cr-Mo alloyed, metalcored wire for single- or multilayer welding of creep resistant steels up to 600 °C with Ar-CO₂ 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

10CrMo9-10, 10CrMo11, 16CrMo9-3, 11CrMo9-10, 26CrMo7, G17CrMo9-10, G19CrMo9-10, ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; A 335 Gr. P22; A 336 Gr. F22; A 426 CP22

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

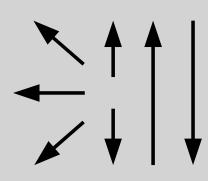
	Gas	C	Si	Mn	Cr	Mo
wt-%	M21	0.06	0.35	1.10	2.20	1.00

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	-10°C
s	550 (≥540)	740 (620–760)	23 (≥18)	110 (≥47)	90

s stress relieved 710°C / 60min – shielding gas M21

Operating data

	Polarity:	Shielding gas:	ø (mm)
	DC (+)	(EN ISO 14175) M21	1.0
			1.2
			1.4
			1.6

Welding with standard GMAW-facilities possible

Approvals

TÜV (12572), CE