

AA MCrMo1

CATEGORY FCAW Flux-Cored

TYPE Seamless metal core wire without slag with M21, for heat and creep resistant applications

APPLICATIONS Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.

PROPERTIES Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use in the field short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production environments and CrMo-steels up to 550 °C (1022°F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

CLASSIFICATION

AWS	5.28: E80C-B2 H4 5.28M: E55C-B2 H4
EN ISO	17634-A: T CrMo1 M M 1 H5 17634-B: T 55 T15 1M 1CM H5

SUITABLE FOR

Materials	DIN	EN	ASTM
Boiler steels	13CrMo44, 24CrMo5	13CrMo4-5	Typical
Cast steels	GS 17CrMo55, GS 22CrMo54	G17CrMo5-5 G22CrMo5-4	A 387 Gr. 11-12
-	similarly alloyed heat treatable steels. similarly alloyed cementation and nitrided steels.		

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS UNDER M21

C	Mn	Si	P	S	Cr	Mo
0.05	1.4	0.3	<0.015	<0.015	1.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		
				RT	-20°C	-40°C
SR	>460	550-740	>20	>80	>47	>27

SR: stress relief annealed 675 - 705°C (1247-1301°F) / 60 min

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
1.2	14-29	90-300	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.6	25-36	180-420	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21