

## AA MCrMo2

**CATEGORY** FCAW Flux-Cored

**TYPE** Seamless metal core wire for heat and creep resistant applications.

**APPLICATIONS** Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.

**PROPERTIES** Good arc striking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. 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: E90C-B3 H4
	5.28M: E62C-B3 H4
EN ISO	17634-A: T CrMo2 MM1H5

SUITABLE FOR	Materials	DIN	EN	ASTM
	Boiler steels	10CrMo9-10	10CrMo9-10	typical
	-	10CrSiMoV7	12CrMo9-10	A 387 Gr. 22
	-	12CrMo9-10	-	-

**APPROVALS** TUV, CE approved

**WELDING POSITIONS:**



### WELD METAL ANALYSIS UNDER M21

C	Mn	Si	Cr	Ni	Mo	P	S
0.07	1.0	0.3	2.3	-	1.1	<0.015	<0.015

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-20°C	-60°C	
SR	>540	620-820	>18	>80	>47		

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
1.0	14-26	70-220	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.2	14-31	90-330	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