

## AA BCrMo1

**CATEGORY** FCAW Flux-Cored

**TYPE** Medium alloyed flux-cored wire for CO2 and M 21 with basic slag.

**APPLICATIONS** Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.

**PROPERTIES** Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for the economic processing on high-temperature resistant CrMo-steels up to 550 °C. X-ray-proof seams with negligible formation of spatter.

**CLASSIFICATION**

AWS	5.29: E80T5-B2 H4 5.29 M: E550T5-B2 H4
EN ISO	17634-A: T CrMo1 B M 3 H5

**SUITABLE FOR** 13CrMo44, 13CrMo4-5, A 387 Gr. 11-12, 24CrMo5, GS 17CrMo55, GS 22CrMo54, G 17CrMo5-5, G22CrMo5-4

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	P	S	Cr	Mo
0.07	1.1	0.3	< 0.012	< 0.012	1.1	0.5

**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
				RT °C	-40°C	-60°C	
680°C/2hr	> 480	580-700	> 20	> 80			
920°C/0.5hr	> 320	450-550	> 26	> 100			

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool	kg / pallet
1.2	23-33	230-320	K 202	5	
1.2	23-33	230-320	K 300	15	
1.6	25-34	250-380	K 300	15	

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M21