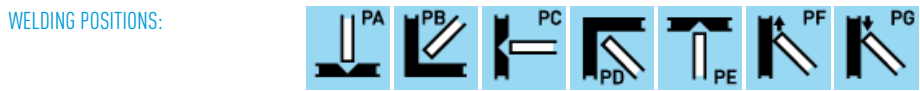


CATEGORY	FCAW Flux-Cored	
TYPE	Seamless rutile core wire with slag support for heat and creep resistant steels	
APPLICATIONS	Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.	
PROPERTIES	Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of CrMo-steels up to 550°C.	
CLASSIFICATION	AWS	A 5.29: E81T1-B2M H4 A 5.36: E81T1-M21PY-B2-H4
	EN ISO	17634-A: T CrMo1 P M21 1 H5
	F-nr	6
	FM	3

SUITABLE FOR	Typ 1Cr0,5Mo, ISO 15608: -5,1 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 13CrMo4-5, 15CrMo5, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5 ASTM A 182 Gr. F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12
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APPROVALS	CE
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.06	0.3	1	0.015	0.015	1.1	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	RT	Impact Energy (J) ISO-V
675°C- 705°C /1h	540	620	20	70	-20°C 50

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG / SPOOL	KG / PALLET
1.2	14-29	90-300	K-300	16	1024

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175