


CATEGORY	FCAW Flux-Cored																										
TYPE	Medium alloyed flux-cored wire for M21 with basic slag.																										
APPLICATIONS	Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.																										
PROPERTIES	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.																										
CLASSIFICATION	AWS	A 5.29: E80T5-B2M H4																									
	AWS	A 5.36: E80T5-M21PY-B2-H4																									
	EN ISO	17634-A: T CrMo2 B M21 3 H5																									
	F-nr	6																									
	FM	4																									
SUITABLE FOR	2.25% Cr / 1% Mo 1.7380, 1.7276, 1.7281, 1.7383, 1.7259, 1.7379, 1.7382 10CrMo9-10, 10CrMo11, 16CrMo9-3, 11CrMo9-10, 26CrMo7, G17CrMo9-10, G19CrMo9-10, GS-18 CrMo 9 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 J 22091, J 21890																										
APPROVALS	CE																										
WELDING POSITIONS:																											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.3</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>2.5</td> <td>1</td> </tr> </tbody> </table>				C	Si	Mn	P	S	Cr	Mo	0.05	0.3	1.2	0.015	0.015	2.5	1									
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GAS ACCORDING EN 14175	M21																										