

CATEGORY	SAW Arc Submerged	
TYPE	High- basicity flux-cored wire for submerged-arc welding. Type P22	
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. Flux FL 150 of FL 160 can be used in combination with this wire.	
CLASSIFICATION	AWS	A 5.23: F9P2-ECB3-B3
	EN ISO	24598-A: S T Z CrMo2 FB
	F-nr	6
	FM	4
SUITABLE FOR	Boiler steels 10CrMo9-10, 10CrSiMoV7, 12CrMo9-10, A 387, CrMo2	

APPROVALS CE

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.09	0.25	0.9	0.015	0.015	2.3	1.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
675°C- 705°C /1h	560	640	20	100

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG / SPOOL / DRUM	KG / PALLET
2,0	28-34	180-320	K-415 / DRUM	25 / 300	1000
2,4	28-38	250-500	K-415 / DRUM	25 / 300	1000
3,2	28-40	400-800	K-415 / DRUM	25 / 300	1000
4,0	28-40	500-900	K-415 / DRUM	25 / 300	1000

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175