

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.36/SFA-5.36	AWS A5.36M/SFA-5.36M
T CrMo2 P M21 1 H5	T62T1-1M21-2C1M-H5	E91T1-M21PY-B3-H4	E621T1-M21PY-B3-H4

Characteristics and typical fields of application

Seamless rutile copper coated flux-cored wire for the welding of creep resistant steels up to 600°C with Ar/CO₂ shielding gas, designed for the welding of 2.25 % Cr and 1% Mo alloyed creep-resistant base metals

Main features: good weldability in all welding positions, fast freezing and easy to remove slag, no spatter at low parameters, good mechanical properties after heat treatment and low content of diffusible hydrogen.

Base materials

Creep resistant steels and similar alloyed cast steels,

1.7380 10CrMo9-10, 1.7276 10CrMo11, 1.7281 16CrMo9-3, 1.7383 11CrMo9-10, 1.7379 G17CrMo9-10, 1.7382 G19CrMo9-10

ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; 335 Gr. P22; A 336 Gr. F22; A 426 Gr. CP22

Typical analysis of all-weld metal (wt.-%)

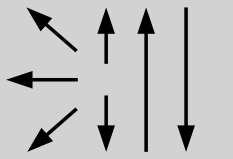
	Gas	C	Si	Mn	Cr	Mo
wt.-%	M21	0.06	0.40	0.80	2.20	1.00

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20°C
s	570 (≥540)	640 (620–7600)	19 (≥ 18)	60 (≥ 47)

s stress relieved 690°C / 1h – shielding gas M21

Operating data

	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M21	ø (mm) 1.2
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Welding with standard GMAW power source possible

Approvals

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