

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.36/SFA-5.36	AWS A5.36M/SFA-5.36M
T CrMo1 M M21 1 H5	T55T15-1M21-1CM-H5	E81T15-M21PY-B2-H4	E551T15-M21PY-B2-H4

Characteristics and typical fields of application

Seamless, Cr-Mo alloyed, metalcored wire for single- or multilayer welding of creep resistant steels up to 500°C with Ar-CO₂ shielding gas.

Features include: high yield, good weldability, excellent bead appearance, very low spatter losses. Wire with very low amount of diffusible hydrogen (< 3ml/100g) that reduces the risk of cracks.

Base materials

1.7335 13CrMo4-5, 1.7262 15CrMo5, 1.7728 16CrMoV4, 1.7218 25CrMo4, 1.7225 42CrMo4, 1.7258 24CrMo5, 1.7354 G22CrMo5-4, 1.7357 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

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

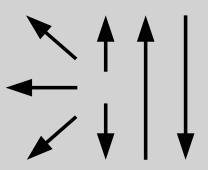
	Gas	C	Si	Mn	Cr	Mo
wt-%	M21	0.06	0.40	1.10	1.20	0.50

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	-10°C	-20°C
s	520 (≥470)	620 (550–690)	22 (≥20)	110 (≥47)	90	80

s stress relieved 690°C / 60min – shielding gas M21

Operating data

	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M21	Ø (mm)
			1.0
			1.2
			1.4
			1.6

Welding with standard GMAW power source possible

Approvals

TÜV, DB, CE