

## Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36/SFA-5.36	AWS A5.36M/SFA-5.36M
T46 0 Mo P M21 1 H5	T550T1-1M21-2M3-PH5	E81T1-M21P0-A1-H4	E551T1-M21P0-A1-H4
EN ISO 17634-A			
T MoL P M21 1 H5			

## Characteristics and typical fields of application

Seamless rutile, Molybdenum alloyed flux cored wire, which provides easy all-position weld ability, primarily designed for the welding of 0,5% Mo alloyed base materials, that are used for the fabrication of vessels, high-pressure storage tanks, pipe systems as well as for structural steel applications. Main features: good weldability in all positions, good bead appearance and fast freezing, easy to remove slag and depositions with low contents of diffusible hydrogen. (< 4ml/100g weld metal)

## Base materials

Creep resistant steels and similar alloyed cast steels,

16Mo3, S235JR-S355JR, P195TR1-P265TR1, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300

ASTM A 29 Gr, 1016; A 106 Gr. A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr., C, D; A 335 Gr. P1; A 501 Gr. B; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65

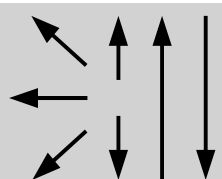
## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Mo
wt-%	<b>0.06</b>	<b>0.2</b>	<b>0.75</b>	<b>0.4</b>

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	0°C	-20 °C
s	<b>550</b> (≥ 470)	630 (≥ 550 – 680)	<b>24</b> (≥ 22)	<b>100</b> (≥ 47)	<b>60</b> (≥ 27)
s stress relieved 620°C / 1 h – shielding gas M21					

## Operating data

	<b>Polarity:</b> DC ( + )	<b>Shielding gases:</b> (EN ISO 14175) M21	<b>ø (mm)</b> 1.2
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Welding with standard GMAW-facilities possible.

Preheating, interpass temperature and post weld heat treatment as required by the base metal. For heavy walled components an interpass temperature to a min. 150°C recommended. Final PWHT should be carried out between 560°C to 620°C for a minimum of 1 hour.

## Approvals

TÜV; CE