

Classifications				
EN ISO 17632-A	EN ISO 17632-B	EN ISO 17634-A	AWS A5.36	AWS A5.36M
T 46 0 Mo P M 1 H5	T550T1-1M-2M3-PH5	T MoL P M 1 H5	E81T1-M21P0-A1-H4	E551T1-M21P0-A1-H4

Characteristics and typical fields of application

Seamless rutile, Molybdenum alloyed, flux cored wire for single or multipass welding of steels having similar properties and resistant to creep up to 450°C with Ar-CO₂ shielding gas. 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.

Base materials

EN 10008-2: P235GH, P265GH, P295GH, P355GH, 16Mo3, 18MnMo4-5, 20MnMoNi4-5

EN 10028-3: P275NH, P355NH, P460NH

EN 10028-6: P355QH, P460QH

EN 10213-2: GS-17CrMo55, GS-22CrMo5, GS-22CrMoV32, GS-CrMo54, 15CrMo3, 13CrMoV42

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

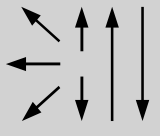
	C	Si	Mn	Mi
wt.-%	0.06	0.2	0.75	0.4

Mechanical properties of all-weld metal

Heat-treat-ment	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	0 °C	-20 °C
S	550 (≥ 470)	630 (≥ 550 – 680)	22 (≥ 20)	100 (≥ 47)	60 (≥ 47)

S stress relieved 620°C / 1 h – shielding gas Ar + 15 – 25 % CO₂

Operating data

	Polarity: DC (+)	Shielding gases: Argon + 15 – 25 % CO ₂ 14 – 20 l/min	Ø (mm) 1.2	Amps A 180 – 280	Voltage V 22 – 30
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Welding with standard GMAW-facilities possible.

Approvals

TÜV; CE