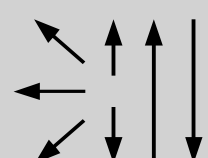


Classifications						
EN ISO 17634-A	EN ISO 17634-B	AWS A5.36		AWS A5.36M		
T CrMo2 M M21 1 H5	T62T15-1M21-2C1M-H5	E90T15-M21PY-B3-H4		E620T15-M21PY-B3-H4		
Characteristics and typical fields of application						
Seamless, Cr-Mo alloyed, metalcored wire for single- or multilayer welding of creep resistant steels up to 600 °C with Ar-CO ₂ 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						
10CrMo9-10, 10CrMo11, 16CrMo9-3, 11CrMo9-10, 26CrMo7, G17CrMo9-10, G19CrMo9-10, ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; A 335 Gr. P22; A 336 Gr. F22; A 426 CP22						
Typical analysis of all-weld metal (wt.-%)						
	Gas	C	Si	Mn	Cr	Mo
wt-%	M21	0.06	0.35	1.10	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	-10°C	
s	550 (≥540)	740 (620–760)	23 (≥18)	110 (≥47)	90	
s stress relieved 710°C / 60min – shielding gas M21						
Operating data						
	Polarity: DC (+)		Shielding gas: (EN ISO 14175) M21		ø (mm) 1.2 1.4 1.6	
Welding with standard GMAW power source possible						
Approvals						
TÜV, CE						