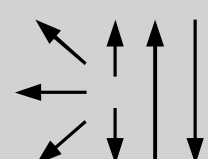


Classifications					
<b>EN ISO 17632-A</b>		<b>EN ISO 17632-B</b>		<b>EN ISO 17634-A</b>	
T46 2 Mo M M21 1 H5		T552T15-1M21-2M3-H5		T Mo M M21 1 H5	
<b>AWS A5.36</b>			<b>AWS A5.36M</b>		
E80T15-M21P0-A1-H4			E550T15-M21P2-A1-H4		
Characteristics and typical fields of application					
Seamless, Molybdenum alloyed, metalcored wire for single- or multilayer welding of creep resistant steels up to 450°C with Ar-CO <sub>2</sub> shielding gas. Features include: high yield, good weldability, excellent bead appearance and low spatter losses. Wire with very low amount of diffusible hydrogen (<3ml/100g) that reduces the risk of cracks.					
Base materials					
16Mo3, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65					
Typical analysis of all-weld metal (wt.-%)					
	Gas	C	Si	Mn	Mo
wt-%	M21	0.09	0.35	1.10	0.50
Mechanical properties of all-weld metal					
Condition	Yield strength R <sub>p0.2</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	%	-20°C	
a	<b>550</b> (≥470)	<b>630</b> (550 – 680)	<b>25</b> (≥22)	<b>90</b> (≥47)	
a      annealed 620°C / 60min – shielding gas M21					
Operating data					
	<b>Polarity:</b> DC ( + )		<b>Shielding gas:</b> (EN ISO 14175) M21		<b>ø (mm)</b>
					1.0
					1.2
					1.4
				1.6	
Welding with standard GMAW power source possible					
Approvals					
TÜV, DB, CE					