

## Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.36	AWS A5.36M
T55 6 1NiMo M M21 1 H5	T625T15-1M21A-N2M2-UH5	E90T15-M21A8-K1-H4	E620T15-M21A6-K1-H4

## Characteristics and typical fields of application

Seamless, Nickel-Molybdenum alloyed, metalcored wire for single- or multilayer welding of low alloyed and high strength steels with Ar-CO<sub>2</sub> shielding gas. Features include: high yield, good weldability, excellent bead appearance, low spatter losses and exceptional mechanical properties at low temperatures. This wire is especially suitable for root pass welding in off-shore and pipeline applications.

## Base materials

S420N-S460N, S420M-S460M, S460Q-S555Q, S460QL-S550QL, P460N,P460NH, L415NB, L415MB-L555MB, L415QB-L555QB, PAS 460-550, alform 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL, 20MnMoNi4-5, 15NiCuMoNb5-6-4  
ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X60, X65, X70, X80, X60Q, X65Q, X70Q, X80Q

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

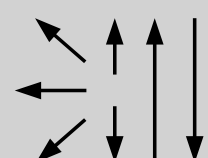
	Gas	C	Si	Mn	Ni	Mo
wt-%	M21	0.06	0.45	1.3	1.00	0.50

## Mechanical properties of all-weld metal

Condition	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	%	-60°C
u	<b>690</b> (≥550)	<b>750</b> (640–820)	<b>22</b> (≥18)	<b>60</b> (≥47)

u untreated, as welded – 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

CE