

AA BCrMo1

CATEGORY FCAW Flux-Cored

TYPE Medium alloyed flux-cored wire for CO2 and M 21 with basic slag.

APPLICATIONS Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.

PROPERTIES Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for the economic processing on high-temperature resistant CrMo-steels up to 550 °C. X-ray-proof seams with negligible formation of spatter.

CLASSIFICATION

AWS	5.29: E80T5-B2 H4 5.29 M: E550T5-B2 H4
EN ISO	17634-A: T CrMo1 B M 3 H5

SUITABLE FOR 13CrMo44, 13CrMo4-5, A 387 Gr. 11-12, 24CrMo5, GS 17CrMo55, GS 22CrMo54, G 17CrMo5-5, G22CrMo5-4

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	P	S	Cr	Mo
0.07	1.1	0.3	< 0.012	< 0.012	1.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				RT °C	-40°C	-60°C	
680°C/2hr	> 480	580-700	> 20	> 80			
920°C/0.5hr	> 320	450-550	> 26	> 100			

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	Spool type	kg / spool	kg / pallet
1.2	23-33	230-320	K 202	5	
1.2	23-33	230-320	K 300	15	
1.6	25-34	250-380	K 300	15	

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21