

AA BCrMo2

CATEGORY FCAW Flux-Cored

TYPE Medium alloyed flux-cored wire for M21 with basic slag.

APPLICATIONS Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.

PROPERTIES Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.

CLASSIFICATION
 AWS A5.29: E90T5-B3M H4
 A5.36: E90T5-M21P0-B3-H4
 EN ISO 17634-A: T CrMo2 B M 3 H5

SUITABLE FOR Boiler steels 10CrMo9-10, 10CrSiMoV7, 12CrMo9-10, A 387, CrMo2

APPROVALS CE Approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	S	P
0,07	1,0	0,3	2,3	-	1,1	0,015	0,015

MECHANICAL PROPERTIES TYPICAL (82%AR-18%CO2)

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	RT	Impact Energy (J) ISO-V		Hardness HRc / HV
					0°C	-20°C	
SR	> 540	620-760	18	120	80	60	

SR stress relief annealed 675-705°C / 60 min.

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Current (A)	Voltage (V)	kg / spool	kg / pallet
1,2	23-33	230-320	16	1024
1,6	25-34	250-380	16	1024

REDRYING TEMPERATURE NA

GAS ACC. EN-ISO 14175 M21