

AA BMo

CATEGORY FCAW Flux-Cored

TYPE High-basic seamless flux-cored wire for welding creep resistant steels under M21

APPLICATIONS Steel and vessel construction, boiler works, mechanical engineering and pipework.

PROPERTIES Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).

CLASSIFICATION

AWS	5.29: E 80T5-A1M H4
	5.29 M: E55C-G H4
EN ISO	17634-A: T Mo B M 3 H5

SUITABLE FOR HI, HII, 17Mn4, 19Mn5, 15Mo3, 16Mo3, P235GH, P265GH, P295GH, 16Mo3 typical, A 204 Gr. A - C, ASTM A106 gr. A-B-C, St 35.8, St 45.8, StE 210.7 TM - StE 480.7 TM, P235T1/T2 - P355N, L210 - L485, StE 255 to StE 460, S255 - S460, 1.5415, 1.0481, 1.0482, 1.0425, 1.0354

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	P	S	Mo
0.05	1.4	0.3	<0.015	<0.015	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
				-20°C	-40°C	-60°C	
AW	>460	550-740	>22	>60	>47		
SR	>460	550-740	>22	>60	>47		

AW: as welded SR: stress relief annealed 605-635°C (1121-1175°F)

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	type spool / drum	kg / spool / drum	kg / pallet
1.2	21-29	160-280	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21