

AA MCrMo2

CATEGORY FCAW Flux-Cored

TYPE Seamless metal core wire for heat and creep resistant applications.

APPLICATIONS Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.

PROPERTIES Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

CLASSIFICATION

AWS	5.28: E90C-B3 H4 5.28M: E62C-B3 H4
EN ISO	17634-A: T CrMo2 MM1H5

SUITABLE FOR

Materials	DIN	EN	ASTM
Boiler steels	10CrMo9-10	10CrMo9-10	typical
-	10CrSiMoV7	12CrMo9-10	A 387 Gr. 22
-	12CrMo9-10	-	-

APPROVALS TUV, CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS UNDER M21

C	Mn	Si	Cr	Ni	Mo	P	S
0.07	1.0	0.3	2.3	-	1.1	<0.015	<0.015

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	-20°C	-60°C	
SR	>540	620-820	>18	>80	>47		

SR: stress relief annealed 675 - 705°C (1247-1301°F) / 60 min

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
1.0	14-26	70-220	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.2	14-31	90-330	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600
1.6	25-36	180-420	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21