

AA MMo

CATEGORY FCAW Flux-Cored

TYPE Seamless metal core wire without slag with M21, for heat and creep resistant applications.

APPLICATIONS Vessel and steel construction, mechanical engineering boiler and pipe work.

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 environments and Mo-steels up to 500 °C (932 °F) . 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: E80 C-D2-H4
	5.28M: E55C-D2-H4
EN ISO	17634-A: T Mo M M 1 H5
	17634-B: T 55 T15 1M 2M3 H5

SUITABLE FOR

(Boiler steels) **DIN:** H1, H11, 17Mn4, 19Mn5, 15Mo3, 16Mo3 **EN:** P235GH, P265GH, P295GH, 16Mo3
 (Pipe steel) **DIN:** St35.8, St45.8, StE 210.7 TM - StE 480.7 TM **EN:** P235T1/T2 - P355N, L210 - L485
 (Fine grain structural steel) **DIN:** StE 255 tot StE 460 **EN:** S255 - S460
ASTM: A 204 Gr. A - C, A 106 Gr. A - C
 1.5415, 1.0481, 1.0482, 1.0425, 1.0354

APPROVALS CE approved



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	P	S	Mo
0.05	1.3	0.7	<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 and SR	>460	550-740	>22	>47	>47		

AW: as welded SR: stress relief annealed 605 - 635 °C (1121-1175°F) / 60 min

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
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