


AA RCrMo1

CATEGORY	FCAW Flux-Cored																								
TYPE	Seamless rutile core wire with slag support for heat and creep resistant steels																								
APPLICATIONS	Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.																								
PROPERTIES	Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of CrMo-steels up to 550°C.																								
CLASSIFICATION	AWS	A5.29: E81T1-B2M H4 A5.36: E81T1-M21PY-B2-H4																							
	EN ISO	EN ISO 17634-A: T CrMo1 P M21 1 H5																							
SUITABLE FOR	Heat and creep resistant boiler steel, GS 22CrMo54, G17CrMo5-5, G22CrMo5-4, 13CrMo 4-5, 16CrMo 4-4, G-17CrMo 5-5, 24CrMo5, 25CrMo4, 21 CrMo 3, 25 CrMo 4, 17CrMo55 ASTM: A182 grades F11/F12, A199/A200 grade T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12																								
APPROVALS	CE approved																								
WELDING POSITIONS:																									
WELD METAL ANALYSIS UNDER M21	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>1.0</td> <td>0.3</td> <td><0.015</td> <td><0.015</td> <td>1.1</td> <td>0.5</td> </tr> </tbody> </table>						C	Mn	Si	P	S	Cr	Mo	0.05	1.0	0.3	<0.015	<0.015	1.1	0.5					
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MECHANICAL PROPERTIES (M21)	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A5 (%)</th> <th rowspan="2">RT</th> <th colspan="3">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>SR</td> <td>620</td> <td>540</td> <td>>20</td> <td>70</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>						Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	RT	Impact Energy (J) ISO-V			-20°C	-40°C	-60°C	SR	620	540	>20	70			
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REDRYING TEMPERATURE	Not required																								
GAS ACC. EN ISO 14175:	M21																								