

AA RMo (Co2)

CATEGORY FCAW Flux-Cored

TYPE Fluxcored rutile welding wire with rapidly solidifying slag for Co2

APPLICATIONS Steel and vessel construction, mechanical engineering and pipework.

PROPERTIES Excellent weld puddle manipulation with good out-of-position welding properties under Co₂. Particularly suited for MAG orbital welding applications when intermediate cleaning is preferred to be skipped. Low spatter loss, easy slag removal. Suitable for economic welding of creep resistant Mo-steels up to 500°C (932°F).

CLASSIFICATION
 AWS 5.29: E81T1-AC1
 EN ISO 17632-A: T 46 2 Mo RC2

SUITABLE FOR HI, HII, 17Mn4, 19Mn5, 15Mo3, 16Mo3, P235GH, P265GH, P295GH, 16Mo3, ASTM A 204 Gr. A - C, A 106 Gr. A -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, 1.0482, 1.0481, 1.0354

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	P	S	Mo
0.05	1.25	0.5	<0.015	<0.015	0.5

ALL WELD METAL MECHANICAL PROPERTIES (CO2)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				RT	-20°C	-60°C	
AW	>470	550-650	>22	>70	>47		
SR	>470	550-680	>22	>70	>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 / 15 / 300	1000 / 1080 / 1000

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: C1