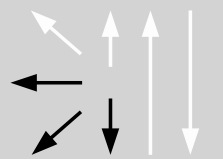


Classifications						
EN ISO 17632-A	EN ISO 17632-B	EN ISO 17634-A	EN ISO 17634-B			
T46 6 Mo B M 3 H5	T556T5-0M-2M3-H5	T Mo B M 3 H5	T55T5-0M-2M3-H5			
AWS A5.36			AWS A5.36M			
E80T5-M21P8-A1-H4			E550T5-M21P6-A1-H4			
Characteristics and typical fields of application						
Seamless, Molybdenum alloyed, basic wire for single- or multilayer welding in boiler, pressure vessel, pipeline and steel construction, preferably for creep resistant steel qualities with 0.5% Mo up to 500°C with Ar-CO <sub>2</sub> shielding gas. Features include: excellent impact values at low temperatures (-60°C) in as welded conditions and after long post weld heat treatments (620°C / 15h) with low spatter losses. Wire with very low amount of diffusible hydrogen in weld metal (<1.5ml/100g) that reduces the risk of cracks.						
Base materials						
16Mo3, S235JR-S355JR, P195TR1-P265TR1, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300 ASTM A 29 Gr, 1016; A 106 Gr. A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr., C, D; A 335 Gr. P1; A 501 Gr. B; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65						
Typical analysis of all-weld metal (wt.-%)						
	Gas	C	Si	Mn	Mo	
wt-%	M21	0.08	0.35	1.00	0.50	
Mechanical properties of all-weld metal						
Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
				+20°C	-40°C	-60°C
u	<b>520</b> (≥470)	<b>600</b> (550–680)	<b>24</b> (≥22)	<b>210</b>	<b>150</b>	<b>130</b> (≥47)
s	<b>490</b> (≥470)	<b>580</b> (550–680)	<b>26</b> (≥22)	<b>190</b>	<b>140</b>	<b>120</b> (≥47)
u	untreated, as welded – shielding gas M21					
s	annealed 620°C / 3h – shielding gas M21					
Operating data						
	<b>Polarity:</b> DC (+)		<b>Shielding gas:</b> (EN ISO 14175) M21		<b>ø (mm)</b>	
					1.2	
					1.4	
				1.6		
Welding with standard GMAW-facilities possible Preheating, interpass temperature and post weld heat treatment as required by the base metal. For heavy walled components an interpass temperature to a min. 150°C recommended. Final PWHT should be carried out between 560°C to 620°C for a minimum of 1 hour.						
Approvals						
TÜV(12577), CE						