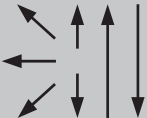


Classifications						
EN ISO 17634-A			AWS A5.29			
T MoL P M 1 H5			E81T1-A1MH4			
Characteristics and typical fields of application						
Seamless rutile, Molybdenum alloyed, flux cored wire for single or multipass welding of steels having similar properties and resistant to creep up to 450°C with Ar-CO ₂ shielding gas. Main features: good weldability in all positions, good bead appearance and fast freezing, easy to remove slag and depositions with low contents of diffusible hydrogen.						
Base materials						
EN 10028-2: P235GH - P265GH - P295GH - P355GH - 16Mo3 - 18MnMo4-5 - 20MnMoNi4-5						
EN 10028-3: P275NH - P355NH - P460NH, EN 10028-6: P355QH - P460QH - P500QH						
EN 10213-2: GS-17CrMo55 - GS-22CrMo5 - GS-22CrMoV32 - GS-CrMo54 - 15CrMo3 - 13CrMoV42						
Typical analysis of all-weld metal (wt.-%)						
C	Mn	Si	P	S	Mo	GAS
0.06	0.90	0.45	< 0.025	< 0.025	0.50	M21
Mechanical properties of all-weld metal – typical values (minimum values)						
Condition	Yield strength R _{p0.2}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa		%	20°C	
u	470	550		20	70	
u: untreated, as welded – shielding gas Ar + 18% CO ₂						
Operating data						
	Ø (mm)	Current A		Voltage V		
	1.00	160 - 270		21 - 33		
	1.20	190 - 320		22 - 34		
	1.40	200 - 350		23 - 35		
	1.60	210 - 380		23 - 36		
	2.00	230 - 400		25 - 38		
	2.40	350 - 450		30 - 40		