

Classifications

EN ISO 17634-A:2008	: T (CrMo 2) P C 1	AWS A5.29-10	: E91T1-B3C
EN ISO 17634-B:2008	: T62 T1-1C-2C1M	AWS A5.36-12	: E91T1-C1PZ-B3
JIS Z 3318	: T62 T1-1C-2C1M	KS D 7121	: YF2CM-C

Description

- It is designed for welding of 620MPa 2.25%Cr-1% Mo steels used for high pressure vessels, oil refining industries, steam pipes of boilers etc (ASTM A182 Gr. F21,F22,F22a, A193 Gr. B16, A213 Gr. T22, A250 Gr. T22, A336 Gr. F21,F22, A356 Gr. 10, A387 Gr. 21,22; A389 Gr. C24, A542 Gr. 2A, 2B, A691 Gr. 12)
- The weld metal contain about 2.25%Cr, 1%Mo and has good crack and heat resistance
- Wire is a titania type of flux cored wire for all-position welding
- It has excellent creep rupture strength, easy slag removal and good weld soundness

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15-25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr	Mo
CO ₂	0.05	0.51	1.18	0.008	0.011	2.25	1.03

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	PWHT
AWS A5.29	min. 540	620~760	min. 17	
EN ISO 17634-B	min. 530	620~820	min. 15	
Example (CO ₂)	630	680	24	690°Cx1Hr

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- Preheat at 160~190°C and PWHT at 690°C

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		

Approvals

Shielding gas	LR
CO ₂	E91T-B3