

**Classifications**

|                     |                 |              |                 |
|---------------------|-----------------|--------------|-----------------|
| EN ISO 17634-A:2008 | : T (Mo) P C 1  | AWS A5.29-10 | : E81T1-A1C     |
| EN ISO 17634-B:2008 | : T55 T1-1C-2M3 | AWS A5.36-12 | : E81T1-C1PZ-A1 |
| JIS Z 3318          | : T55 T1-1C-2M3 | KS D 7121    | : YFM-C         |

**Description**

- It is designed for welding of 560MPa 0.5% Mo steels used for high pressure vessels, oil refining industries, steam pipes of boilers etc (ASTM A161 T-1, A182 F1, A204 Gr.A/B, A234 Gr. WP1, A336 Gr.F1 A352 Gr. LC1, A356 Gr. 2, A426 Gr. CP1,CP15, A533 Gr.A1)
- The weld metal contain about 0.5% Mo so it has good crack and heat resistance
- Wire is a titania type of flux cored wire for all-position welding
- It has very efficient welding due to higher deosition rate particularly

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

| Shielding gas   | C    | Si   | Mn   | P     | S     | Mo   |
|-----------------|------|------|------|-------|-------|------|
| CO <sub>2</sub> | 0.02 | 0.55 | 1.21 | 0.008 | 0.010 | 0.53 |

**Typical mechanical properties of all-weld metal**

|                            | Y.S<br>(MPa) | T.S<br>(MPa) | El.<br>(%) | PWHT      |
|----------------------------|--------------|--------------|------------|-----------|
| AWS A5.29                  | min. 470     | 550~690      | min. 19    |           |
| EN ISO 17634-B             | min. 460     | 550~740      | min. 17    |           |
| Example (CO <sub>2</sub> ) | 531          | 610          | 25         | 620°Cx1Hr |

**Notes on usage and welding condition**

- Refer to page 211~213 for more information on usage
- Preheat at 100~200°C and PWHT at 620°C

**Package**

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