

# FCW for Chromium-Molybdenum Low Alloy Steels

## GMX811-B6

AWS A5.29M E551T1-B6C  
A5.29 E81T1-B6C  
ISO 17634-A-T CrMo 5 R C1 1

### Product Features:

- Titania oxide type flux cored arc welding wire.
- All deposited weld metal contains approximately 5 %Cr-0.5 %Mo alloy elements, good for high-temperature service.
- Good for RT examination, good crack resistance.

### Applications:

- Suitable for welding of A213-T5, A335-P5 or similar grade steel.

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

| C    | Si   | Mn   | Cr   | Mo   |
|------|------|------|------|------|
| 0.06 | 0.29 | 0.46 | 4.91 | 0.55 |

Typical mechanical properties of all weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Post Weld Heat Treatment<br>(PWHT)<br>°C / hr |
|-------------------------------------|---------------------------------------|-----------------|-----------------------------------------------|
| 591                                 | 661                                   | 22              | 745                                           |

Size (mm) & recommended welding parameters

| Diameter      |                              | 1.2             | 1.6             |
|---------------|------------------------------|-----------------|-----------------|
| Polarity      |                              | DC+             | DC+             |
| Ampere (A)    | Flat, horizontal position    | 180~260         | 200~320         |
|               | Vertical / overhead position | 160~200         | 180~240         |
| Shielding Gas |                              | CO <sub>2</sub> | CO <sub>2</sub> |

### Note:

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