

FCW for Chromium-Molybdenum Low Alloy Steels

GMX811-B8

AWS A5.29M E551T1-B8C
A5.29 E81T1-B8C
ISO 17634-A-T Z R C1 1

Product Features:

- Titania oxide type flux cored arc welding wire.
- All deposited weld metal contains approximately 9.0%Cr-1.0 %Mo alloy elements, good for high-temperature service.
- Good for RT examination, good crack resistance.

Applications:

- Suitable for welding of A213-T9, A335-P9 or similar grade steel.

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

C	Si	Mn	Cr	Mo
0.06	0.31	0.44	9.34	1.02

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT) °C / hr
483	641	21	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 ₂	CO ₂

Note:

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