

FCW for Chromium-Molybdenum Low Alloy Steels

GMX911-B3

AWS A5.29M E621T1-B3C
A5.29 E91T1-B3C
ISO 17634-A-T CrMo 2 R C1 1

Product Features:

- Titania oxide type flux cored arc welding wire.
- All deposited weld metal contains approximately 2.25 %Cr-1.0 %Mo alloy elements, good for serving temperature $\leq 550^{\circ}\text{C}$.
- Good for RT examination, good crack resistance.

Applications:

- Suitable for welding of 2.25%Cr – 1%Mo steel, such as A387 Gr.22 Cl.1&2 or similar grade steel.

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

C	Si	Mn	Cr	Mo
0.06	0.39	0.56	2.29	1.20

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
657	724	21	690

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~360
	Vertical / overhead position	160~220	180~280
Shielding Gas		CO ₂	CO ₂

Note:

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