FCW 63

Classification

AWS A5.29 : E 81 T1-B2 ISO 12071 T CrMo1 P M 1 H5

Description & Applications

Micro-alloy rutile flux-cored wire with rapidly solidifying slag for Ar-CO_2 mix ,excellent weld puddle manipulation thus used in all-position welding. Particularly suited for economical welding on CrMo steels up to 550° C. Weld Xray quality with low spatter formation. Suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal.

Main applications: Shipbuilding, steel and vessel construction, mechanical engineering and pipe work, steam boiler and steam turbine construction

Base materials

Material	DIN	EN	ASTM
Boiler Steels	13 CrMo 44 24 CrMo5	13 CrMo 4-5	A 182 / A387
cast steels	GS 17CrMo 55 GS 22CrMo 54	GS 17CrMo 5-5 GS 22CrMo 5-4	A 217

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	P	S
0.05	0.3	1.4	1.1	0.5	<0.015	<0.015

All Weld Metal Mechanical Properties

$R_{p0,2}$(MPa)	R_m(MPa)	A_5(%)	KV (J)
>480	580-700	>20	+20°C >80

PWHT : After heat treatment at 680^{0}C/2H

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