



DAIKOFCW 1CrMoB



CREEP RESISTING STEELS
1CrMo

DESCRIPTION

Basic flux cored wire for flat and horizontal position

Basic flux cored wire for prolonged elevated temperature service up to about 550°C, especially in steam generation power plants. Used in chemical and petro-chemical industries for resistance to hydrogen attack in fabrication of hydrocrackers, coal liquefaction plant and NH3 pressure vessel operating at up to 450° C applications. The wire shows excellent weldability in flat and horizontal position, smooth and bright bead, very low spatter losses, easy to remove slag and exceptional mechanical properties even at low temperatures.

SPECIFICATIONS

ISO 17634-A	CrMo1 B M 3	AWS A5.36	E80T5-M21PY-B2
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	M21
Positions	PA, PB, PC	Current	DC+

ASME QUALIFICATIONS

F-No (QW432)	6
A-No (QW442)	3

FERRITE

F-No (QW432)	-
A-No (QW442)	-

PREN

F-No (QW432)	-
A-No (QW442)	-

HARDNESS

F-No (QW432)	-
A-No (QW442)	-

CHEM. COMP. %

DEFAULT

C	0.06
Mn	1.1
Cr	1.2
P	0.02
S	0.02
Mo	0.5
Si	0.45
Cu	0.15

MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R _m MPa	550	610
Yield strength R _{p0.2} MPa	470	470
Elongation A (L ₀ =5d ₀) %	17	18
Impact Charpy ISO-V	-	47J @ 20°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

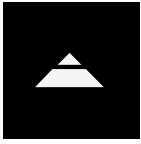
	1.2 mm	1.6 mm
Ampere	100A - 300A	160A - 420A
Voltage	16V - 28V	31V - 35V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool

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The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.





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APPLICATION

Designed for prolonged elevated temperature service up to 550°C, these consumables have primary applications in steam-generating power plants. These consumables excel in various components like piping, turbine castings, steam chests, valve bodies, and boiler superheaters. They also provide corrosion resistance in refineries for sulfur-bearing crude oil (250-450°C) and resist hydrogen attack in chemical and petrochemical industries for hydrocrackers, coal liquefaction plants, and NH₃ pressure vessels (up to 450°C). In the as-welded state, these consumables yield a weld deposit with a useful 300HV hardness, suitable for build-up or hard surfacing to combat metal-to-metal wear and heavy impact. A minimum preheat and interpass temperature of 200°C is recommended, extending up to 300°C for thicker sections. It is crucial to maintain these temperatures throughout the welding cycle and for some time after the completion of welding. With the exception of specific applications, post-weld heat treatment (PWHT) is invariably necessary, typically at a temperature of 690°C, the duration of which depends on the thickness of the section.

ALLOY TYPE

1¼Cr-½Mo alloyed steel consumables for elevated temperature service.

MICROSTRUCTURE

After PWHT, the microstructure consists of tempered bainite.

MATERIALS

EN W.Nr.: 13CrMo 4-5 (1.7355), 13CrMo 4-4 (1.7335), 16CrMo 4-4 (1.7337), 11CrMo 5-5 (1.7339), GS-25CrMo 4 (1.7128), GS-17CrMo 5-5 (1.7357).

ASTM: A387 Gr 11 & 12, A182 F11 & F12, A217 WC6 & WC11, A234 WP11 & WP12, A199 T11, A200 T11, A213 T11 & T12, A335 P11 & P12.

