

AA RMo

CATEGORY FCAW Flux-Cored

TYPE Seamless micro alloyed rutile core wire with rapidly solidifying slag for M21

APPLICATIONS Steel and vessel construction, mechanical engineering and pipework.

PROPERTIES Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).

CLASSIFICATION

AWS	5.29: E81T1-A1M H4 5.29M: E551T1-A1M H4
EN ISO	17634-A: T MoL P M 1 H5 17634-B: T55 T1 1M 2M3 H5

SUITABLE FOR HI, HII, 17Mn4, 19Mn5, 15Mo3, 16Mo3, P235GH, P265GH, P295GH, 16Mo3, ASTM A 204 Gr. A - C, A 106 Gr. A - C, St 35.8, St 45.8, StE 210.7 TM - StE 480.7 TM, P235T1/T2 - P355N, L210 - L485, StE 255 to StE 460, S255 - S460, 1.5415, 1.0482, 1.0481, 1.0354

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	P	S	Mo
0.05	1.3	0.5	<0.015	<0.015	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	RT	Impact Energy (J) ISO-V		Hardness HRC / HV
					-40°C	-60°C	
AW	>460	550-740	>22	>47			
SR	>460	550-740	>22	>47			

AW: as welded SR: stress relief annealed 605-635°C/1h (1121-1175°F)

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	type spool / drum	kg / spool / drum	kg / pallet
1.2	21-29	160-280	D-200 / K-300 / Drum	5 / 16 / 300	1000 / 1024 / 600

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M21