Dual Shield CrMo1

Dual Shield CrMo1 is an all positional rutile, low-hydrogen flux-cored wires for welding 1.25%Cr creep resisting steels. Designed for use in Ar/CO2 shielding gas, it has excellent weldability and produce flat beads with good wetting and appearance as well as good impact toughness down to -20°C after stress relieving

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-B2M EN ISO 17634-A : T CrMo1 P M 2 H5
Approvals	VdTÜV : 12138

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	1Cr 0.5Mo
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
PWHT 1 hour(s) 690 °C	563 MPa	626 MPa	27 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
PWHT 1 hour(s) 690 °C	20 °C	156 J
PWHT 1 hour(s) 690 °C	0 °C	149 J
PWHT 1 hour(s) 690 °C	-20 °C	55 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Cr**	**Mo**
0.06	0.90	0.35	1.29	0.54

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h