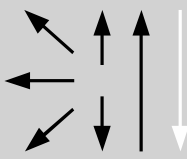


Classifications									
EN ISO 17634-A	EN ISO 17634-B	AWS A5.36	AWS A5.36M						
T CrMo2 P M21 2 H10	T 62T1-1M21-2C1M-H10	E91T1-M21PY-B3-H8	E621T1-M21PY-B3-H8						
Characteristics and typical fields of application									
<p>The welding consumable Böhler CM 2 Ti-FD is a low alloyed, flux-cored wire with rutile filling, primarily designed for the welding of 2.25 % Cr and 1% Mo alloyed creep-resistant base metals (e.g. 10CrMo9-10), that are used for the fabrication of high-pressure vessels and pipe systems. Due to the fast freezing slag system this flux-cored wire provides excellent positional welding characteristics and allows fast travel speeds to be used. This flux cored wire is for welding with normal power sources on DCEP under mixed gas M21</p>									
Base materials									
<p>Creep resistant steels and similar alloyed cast steels, 1.7380 10CrMo9-10, 1.7276 10CrMo11, 1.7281 16CrMo9-3, 1.7383 11CrMo9-10, 1.7379 G17CrMo9-10, 1.7382 G19CrMo9-10 ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; 335 Gr. P22; A 336 Gr. F22; A 426 Gr. CP22</p>									
Typical analysis of all-weld metal (wt.-%)									
	C	Si	Mn	Cr	Mo	P	As	Sn	Sb
wt.-%	0.08	0.25	0.8	2.25	1.1	< 0.015	< 0.005	< 0.005	< 0.005
Mechanical properties of all-weld metal									
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J					
	MPa	MPa	%	+20°C					
a	600 (≥ 540)	700 (620 – 760)	19 (≥ 18)	70 (≥ 47)					
a1	650 (≥ 540)	730 (620 – 760)	19 (≥ 18)	50 (≥ 47)					
a	annealed, 720°C/2 h – shielding gas Ar + 18% CO ₂								
a1	annealed, 690°C/1 h – shielding gas Ar + 18% CO ₂								
Operating data									
	Polarity: DC (+)	Shielding gas: Argon + 15 – 25% CO ₂	Redrying: if necessary 150°C / 10 h	ø (mm) 1.2	Amperage A 150 – 330	Voltage V 23-37			
Preheating, interpass temperature and post weld heat treatment as required by the base metal.									
Approvals									
TÜV (11812.), CE									