BÖHLER CM2 Kb T-FD

Flux cored wire, seamless, creep resistant, basic type

Classifications

EN ISO 17634-A	EN ISO 17634-B	AWS A5.36	AWS A5.36M
T CrMo2 B M21 4 H5	T62T5-0M21-2C1M	E90T5-M21PY-B3-H4	E620T5-M21PY-B3-H4

Characteristics and typical fields of application

Seamless basic flux cored wire for welding of Chromium-Molybdenum alloyed creep resistant steels with an application temperature up to 600 °C with Ar-CO_2 shielding gas.
Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, low spatter losses, easy removable slag, good mechanical properties and high deposition rates with very low contents of diffusible hydrogen in weld metal (< 3ml/100g).

Base materials

10CrMo9-10, 10CrMo11, 16CrMo9-3, 11CrMo9-10, 26CrMo7, G17CrMo9-10, G19CrMo9-10, ASTM A 182 Gr. F22; A 213 Gr. T22; A 234 Gr. WP22; A 335 Gr. P22; A 336 Gr. F22; A 426 CP22

Typical analysis of all-weld metal (wt.-%)

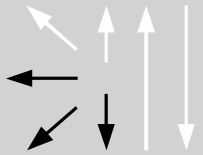
	Gas	C	Si	Mn	Cr	Mo
wt-%	M21	0.07	0.45	1.10	2.20	1.00

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
s	**550** (≥540)	**650** (620–760)	**25** (≥18)	**100** (≥47)

s stress relieved 710°C / 60min – shielding gas M21

Operating data



Polarity:	Shielding gas:	ø (mm)
DC (+)	(EN ISO 14175) M21	1.0 1.2 1.4 1.6

Welding with standard GMAW power source possible

Approvals

CE