Technical data sheet 011121MBA	Cored welding wire # ROBOFIL B CrMoV	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.29 / AWS A 5.29: E90T5-G H4
EN ISO 17634-A: T Z B M 3 H5

DESCRIPTION

- Seamless high fill copper coated basic cored tubular wire for semi-automatic gas shielded arc welding
- For single and multiple pass welding of CrMoV alloyed steels for use up to 600°C
- Optimal productivity by combining advantages of both seamless and seamed tubular wires
- H_{DM} guaranteed < 4 ml/ 100g deposited metal on the whole parameter box
- No moisture pick up, excellent wire feeding properties, good weldability and low spatter
- Exceptional mechanical properties

APPLICATIONS

Welding high temperature steels of similar composition
Examples
21CrMoV511, G17CrMoV5-11, GS-17CrMoV511

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ni	V
0.12	0.70	0.25	1.30	1.00	0.40	0.30

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES1

	Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
Q&T [a]	590 - 780	> 440	≥ 15	≥ 47
Q&T [b]	590 - 780	> 440	≥ 15	≥ 47
T [c]	590 - 780	> 500	≥ 15	≥ 47

[a] Quenched & tempered → 30 min 950°C / Air cooling + 16 h at 700°C / furnace cooling down to 300°C.
[b] Quenched & tempered → 30 min 950°C / Oil cooling + 16 h at 700°C / furnace cooling down to 300°C.
[c] Tempered → 6 h at 730°C / furnace cooling down to 300°C

SHIELDING GAS

M21 gas mixtures (Ar + 5 - 25% CO_2) according to EN ISO 14175 - Gas flow rate: 12 - 25 l/min.

OPERATING CONDITIONS

Diameter [mm]	Current type	Current I [A]	Voltage [V]	Stick out [mm]
1.2	DC+ or pulsed	100 - 350	16 - 34	12 - 25
1.6	DC+ or pulsed	160 - 470	20 - 36	15 - 25

WELDING POSITIONS

ROBOFIL B CrMoV is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm	1.6 mm
Spool type	EN ISO 544 : BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us