Union MV CrMo 910

Metal cored wire, low-alloyed

Classifications		
EN ISO 17634-A	EN ISO 17634-B	AWS A5.28
T CrMo 2 M M 2 H5	T62T15-1M-2C1M-H5	E90C-B3H4

Characteristics and typical fields of application

Union MV CrMo 910 is a medium alloyed seamless copper coated cored wire with metal powder filling for GMAW with mixed gas M21 acc. to EN ISO 14175. It is a metal filled wire for the welding of creep resistant steels in boiler-, container- and pipeline-construction. This flux cored wire is suited for all position welding. It is characterized by low oxidizing, a stable and smooth arc, smooth droplet transfer and secure penetration. It is excellent suitable for manual and mechanized welding of single and multilayers.

Base materials

GS-18 CrMo 9 10, 10 CrMo 9 10, 10 Cr Si Mo V7, 12 CrSiMo 8
and covering base materials of group 7 acc. to VdTÜV-Kennblatt 1000

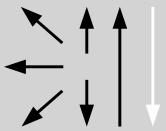
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	P	S	Cr	Mo
wt-%	0.07	0.30	0.85	≤ 0.010	≤ 0.010	2.25	1.0

Mechanical properties of all-weld metal

Heat-treatment	Shielding gas	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	–10 °C
690 °C / 1 h	M21	540	620	17	70	47

Operating data



Polarity:	Shielding gas:	ø (mm)	Spool	Amps A	Voltage V
DC (+)	(EN ISO 14175) M21 Consumption: 15 – 20 l/min	1.2	B300	120 – 300	17 – 31

Approvals

TÜV (12066), CE