

TALCOR B3

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.29: E91T1-B3M	EN ISO 17634-A: T CrMo2 P M

ALLOY TIPE

2.25Cr-1Mo content to be used for the welding of creep resistant steel.

APPLICATIONS

Rutile flux cored wire with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steel. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs. Little spattering, easily removable slag, very good-looking weld bead. To be used under the shield of Ar+CO₂.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

GAS	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
M21	0.08	1.00	0.40	0.010	0.010	2.20	-	1.00	-

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-30°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
M21	after PWHT	570	650	20	150	-	-	-	-

WELDING GUIDELINES

Preheat and interpass temperature 200°C. PWHT at 690°C for an hour.

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN 14175)
Welding positions: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity		
Diameter (mm)		1.2	
Volts (V)		16 ÷ 32	
Intensity (A)		110 ÷ 330	

Diam.	15kg Spool
1.2mm	INFCB312

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com