

LOW ALLOY**GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)**

A 0.5% Mo metal cored wire for use with M21 shielding gas. Diameters less than 1.4mm are all-positional.

Specifications	
Classifications	SFA/AWS A5.28 : E80C-G EN ISO 17632-A : T 50 2 Z M M21 2 H5
Approvals	CE : EN 13479 DB : 42.039.34 UKCA : EN 13479 VdTÜV : 10716

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+-
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	C Mn low alloy steel (0.5 % Mo).
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	588 MPa	663 MPa	25 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-20 °C	79 J

Typical Weld Metal Analysis %			
C	Mn	Si	Mo
M21 shielding gas			
0.06	1.27	0.58	0.51

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-320 A	16-32 V	1.8-12.0 m/min	1.3-7.5 kg/h
1.6 mm	140-450 A	18-36 V	1.5-8.5 m/min	1.6-8.0 kg/h