

Dual Shield MoL

Dual Shield MoL is an all position rutile, low-hydrogen flux-cored wires for welding 0.5%Mo creep resisting steels. Designed for use in Ar/CO₂ shielding gas, it has excellent weldability and produce flat beads with good wetting and appearance with good impact toughness down to -20°C after stress relieving.

Specifications

Classifications	SFA/AWS A5.29 : E81T1-A1M EN ISO 17634-A : T MoL P M 2 H5
Approvals	VdTÜV : 12161

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

Welding Current	DC+
Alloy Type	0.5Mo
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding gas			
PWHT 1 hour(s) 615 °C	563 MPa	626 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 Shielding gas		
PWHT	-20 °C	131 J
PWHT	0 °C	149 J
PWHT	20 °C	156 J

Typical Weld Metal Analysis %

C	Mn	Si	Mo
0.043	0.72	0.25	0.47

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h