

Dual Shield CrMo1

Dual Shield CrMo1 is an all positional rutile, low-hydrogen flux-cored wires for welding 1.25%Cr creep resisting steels. Designed for use in Ar/CO₂ shielding gas, it has excellent weldability and produce flat beads with good wetting and appearance as well as good impact toughness down to -20°C after stress relieving

Classifications Weld Metal	SFA/AWS A5.29 : E81T1-B2M EN ISO 17634-A : T CrMo1 P M 2 H5
Approvals	NAKS/HAKC 1.2MM VdTUV 12138

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

Welding Current	DC+
Alloy Type	1Cr 0.5Mo
Shielding Gas	M21 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
PWHT 1hr 690°C	20 °C	156 J
PWHT 1hr 690°C	0 °C	149 J
PWHT 1hr 690°C	-20 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.06	0.90	0.35	1.29	0.54

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