

PRODUCT DATA SHEET

Trimark TM811-B2



TM811-B2 deposits a weld metal containing 1,25% Cr and 0,5% Mo and is designed for welding creep resistant steels for service up to 550°C. TM811-B2 offers good weldability in all positions, with a fast freezing slag that removes easily. The wire is recommended for single and multi-pass welding in all positions using either 100% CO₂ or 75/25 Ar/CO₂ shielding gases.

Classifications

AWS	A5.29	E81T1-B2-H4
EN	17634-A	T CrMo 1 PM2 H5
EN	17634-B	T55-T1-1M-1CM-H5

Typical Chemical Analysis

% Carbon	0,05	% Phosphorous	0,004
% Manganese	0,57	% Molybdenum	0,46
% Silicon	0,39	% Chromium	1,22
% Sulphur	0,005		

Typical Mechanical Properties (All weld metal in the as welded condition)

	100% CO ₂	75% Ar/25% CO ₂
Yield Strength	591 MPa	763 MPa
Tensile Strength	682 MPa	687 MPa
% Elongation on 5d	20	19
Charpy V-Notch	N/A	N/A

Packing Data (DC+)

Diameter (mm)	Current		Deposition Rate (kg/hr)	Pack Mass (kg)	Item Number
	Volts (V)	Amps (A)			
1,2 Flat & Horizontal	24	175	2,3	15,0 (spool)	W081144
	28	250	4,2		
	30	300	5,8		
1,2 Vertical & Overhead	24	175	2,3		
	26	200	2,9		
	27	225	3,4		
1,6 Flat & Horizontal	28	300	4,2	15,0 (spool)	W081145
	29	350	5,7		
	33	400	7,1		
1,6 Vertical & Overhead	24	200	4,2		
	25	225	2,8		
	26	250	3,2		

Bold indicates optimum parameters for welder appeal.
Suggested shielding gas: 100% CO₂ or Afrox Fluxshield®

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For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

