

CORMET 2



CORMET 2 is a FCW designed for prolonged elevated temperature service up to 600°C. Main areas of application are associated with steam generating power plant, e.g. piping, turbine castings, steam chests, valve bodies and boiler super-heaters. Some of the consumables will also find service in refineries where they are used for corrosion resistance to sulphur bearing crude oil at 250-450°C. Some of the consumables will also find applications in the chemical and petro-chemical industries where they are used for

resistance to hydrogen attack in the fabrication of hydro-crackers, coal liquefaction plant and NH₃ pressure vessels operating at up to 450°C. In the as welded condition the consumables also provide a useful source of 300HV hardness weld deposit for build-up or hardsurfacing to resist metal-to-metal wear and heavy impact.

CLASSIFICATIONS

AWS	A5.29	E91T1-B3M
BS EN	12071	(TCrMo 2 P M 2)

CHEMICAL ANALYSIS

% Carbon	0.060	% Phosphorous	0.010
% Manganese	1.000	% Chromium	2.300
% Silicon	0.300	% Molybdenum	1.000
% Sulphur	0.010	% Copper	0.050

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL PWHT 690°C/1-2h**

Tensile Strength	725 MPa
0.2% Proof Stress	625 MPa
Elongation on 4d	22%
Impact Energy 20°C	>70 J

PACKING DATA

(DC+)

Diameter (mm)	Current (A)		Stickout (mm)	Item Number	Pack Mass (Kg)
	Amps	Volts			
1.20	160 – 260	24 – 30	15 – 25	078-253	15

Suggested gas for FCW welding: Fluxshield

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