

# FILEUR AMC 35

Seamless, Molybdenum alloyed, metalcored wire for single or multipass welding of similar steels resistant to creep up to 450°C with Ar-CO<sub>2</sub> shielding gas. Features include: high yield, good weldability, excellent bead appearance and no spatter or slag. Wire with very low amount of diffusible hydrogen (<3ml/100g) that reduces the risk of cracks.

AWS A5.28: E80C-GMH4

EN ISO 17634-A: T MoL M M 2 H5

## Approvals

TÜV

## Shielding gas

Ar/CO<sub>2</sub> (EN ISO 14175: M21)

## Flow rate

14 - 20 l/min

## Applications

Oil industry and heating plants.

## Main properties of the deposited weld metal after PWHT

M21: R<sub>m</sub>=550-680 N/mm<sup>2</sup> - R<sub>s</sub>>470 N/mm<sup>2</sup> - A%5 $\emptyset$ >20 - KV (-20°C)>47J (~70J)

C=0.06% - Mn=1.40% - Si=0.35% - P<0.025% - S<0.025% - Mo=0.50%







HDM ml/100g<3

PWHT: 620°C for 60min

## Current

D.C.+

## Welding positions

						
AWS	1G	2F	2G	3Gup	4G	5Gup
EN	PA	PB	PC	PF	PE	PF

## Materials to be welded

EN 10028-2: P235GH - P265GH - P295GH - P355GH - 16Mo3 - 18MnMo4-5 - 20MnMoNi4-5

EN 10028-3: P275NH - P355NH - P460NH

EN 10028-6: P355QH - P460QH - P500QH

EN 10213-2: GS-17CrMo55 - GS-22CrMo5 - GS-22CrMoV32 - GS-CrMo54 - 15CrMo3 - 13CrMoV42

## Welding parameters

Diameter (mm)	Current (A)	Voltage (V)
1.00	40-270	11-32
1.20	50-320	12-35
1.40	60-360	14-36
1.60	60-390	16-37
2.00	100-420	17-39
2.40	150-450	18-41