



## AMA 305 M

**Standards:** AWS/ASME SFA 5.29 E81 T5 B2

**Properties :** Metal cored wire for chromium molybdenum steels. The weld metal has resistant to creep . this wire is suitable for welding in all position and root pass with back penetration . .

### All-Weld metal analysis (typical values)% :

Gas	C	Mn	Si	Cr	Mo
M21	0.04	0.7	0.6	1.25	0.5

Shielding gas: DIN EN 439 - M21 ( 15-25% CO<sub>2</sub> , balance Ar)

### Mechanical properties of all-weld metal (typical

Heat treatment	Tensile Strength (N/mm <sup>2</sup> )	Yield 0.2% Strength (N/mm <sup>2</sup> )	Elongation Lo = 5d %	Impact energy (j)	
				0 °C	ISO - V -20 °C
SR	580	480	23	90	60

SR : Heat treated at 700 °C for 1 hour. The heating and cooling speed is 50 °C/h

### Main Application :

Sheet metal work , petroleum chemistry , chemistry , incinerators , heat exchangers

**Delivery:** coil in diameter: 1.2 , 1.6mm & weight 15kg.

**Note:** other weight & sizes are produced upon customers request.

