Cormet™ 2

TOP FEATURES

- High metal recovery
- Smooth arc performance in all positions

TYPICAL APPLICATIONS

- Designed for prolonged elevated temperatures up to 600°C (1112°F)
- Refineries where corrosion resistance to sulphur bearing crude oil is at 250-450°C (482-842°F)
- Petro-Chemical
- Power Plants
- Piping, Turbine Casting, Steam Chests, Valve Bodies, Boiler Superheaters

CLASSIFICATION

AWS A5.29	E91T1-B3C/M-H4
AWS A5.36	E91T1-C1PZ-B3-H4 or E91T1-M21PZ-B3-H4
EN ISO 17634-B	T 62T1-1C/M-2C1M

(depending on shielding gas)

CURRENT TYPE

DC+

WELDING POSITIONS

All

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
C1	Active gas 100% CO_2
Flow rate	15-25 l/min

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Mo	Cu
Min.	0.05					2.00	0.90	
Max.	0.12	1.25	0.80	0.030	0.030	2.50	1.20	0.30
Typical	0.06	1	0.3	0.01	0.01	2.3	1.0	0.05

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT		Min.	Typical 690°C/1h-2h
Tensile strength	**(MPa)**	620	680
0.2% Proof strength	**(MPa)**	540	570
Elongation (%)	**4d**	17	21
	5d	15	19
Impact ISO-V (J)	**+20°C**		150
	-20°C		60
Hardness	**(HV)**		220

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	16.0	CORM2-12N

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.