

# Cormet™ 1

## TOP FEATURES

- Designed for strength and resistance to corrosion
- Cr-Mo Alloyed steel for elevated temperature service to aid creep resistance

## TYPICAL APPLICATIONS

- Piping
- Chemical & Petrochemical Industry
- Steam Generating Power Plant
- Pressure vessels

## CLASSIFICATION

AWS A5.29	E81T1-B2C/M-H4
EN ISO 17634-A	T CrMo1 P C1 2 H5 / T CrMo1 P M21 2 H5
EN ISO 17634-B	T 55T1-1C/M-1CM

## CURRENT TYPE

DC+

## WELDING POSITIONS

All

## SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO <sub>2</sub>
C1	Active gas 100% CO <sub>2</sub>
Flow rate	15-25 l/min

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Mo	Cu
Min.	0.05					1.00	0.40	
Max.	0.12	1.25	0.80	0.03	0.03	1.50	0.65	0.30
Typical	0.06	1.0	0.3	0.01	0.01	1.3	0.55	0.05

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT	Min.	Typical 690°C/1-2h
Tensile strength (MPa)	550	635
0.2% Proof strength (MPa)	470	545
Elongation (%) 4d	19	24
5d	17	22
Impact ISO-V (J) +20°C		150
-20°C		80
Hardness (HV)		200

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	16.0	CORM1-12N

## 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](http://www.lincolnelectric.eu) for any updated information.