

**CORMET I**



CORMET I is a FCW designed for prolonged elevated temperature service up to 550°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 NH<sub>3</sub> 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	E81T1-B2M
BS EN	12071	(TCrMo 1 PM 2)

**CHEMICAL ANALYSIS**

% Carbon	0.060	% Phosphorous	0.010
% Manganese	1.000	% Chromium	1.300
% Silicon	0.300	% Molybdenum	0.550
% Sulphur	0.010	% Copper	0.050

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

Tensile Strength	650 MPa
0.2% Proof Stress	550 MPa
Elongation on 4d	24%
Impact Energy 20°C	>40 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	078-252	15

Suggested gas for FCW welding: Fluxshield

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