



CEWELD AA B Mo

TYPE	High-basic seamless flux-cored wire for welding creep resistant steels under M21	
ANWENDUNGEN	Steel and vessel construction, boiler works, mechanical engineering and pipework.	
EIGENSCHAFTEN	Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).	
KLASSIFIKATION	AWS	A 5.36: E80T5-M21P4-A1-H4
	EN ISO	17634-A: T Mo B M21 3 H5
	F-nr	6
	FM	4

GEEIGNET FÜR	<p>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 1.5415, 1.0481, 1.0482 15 Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65</p>
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ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb
0.073	0.353	1.08	0.025	0.052	0.412	0.078	0.005

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	510	620	24	80	75	HRc
605°C- 645°C 1h	520	620	25	60	55	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 M21



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AA B MO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423207