CEWELD SACW CrMoWV-12

certilas® THE FILLER METAL SPECIALIST

TYPE	Flux-cored wire for submerged-arc welding creep resistant steels.
ANWENDUNGEN	Suited for analogous and similar creep resistant steels in turbine and steam boiler construction as well as in the chemical industry. Recomended for long-term periods up to +650 °C
EIGENSCHAFTEN	Preheating and interpass temperature 400-450 °C (austenitic welding) or 250-300 °C (martensitic welding). Root passes should principally be welded in the martensitic range. Lower preheat and interpass temperatures are possible, yet must be approved by practical welding tests and process qualification tests. After welding cooling to 90±10 °C, followed by tempering at 760 °C for three minutes / mm wall thickness at least for 2 hours. Tempering, if specified, at 1050 °C for 1/2 hour/oil and annealing at 760 °C for 2 hours.
KLASSIFIKATION	
GEEIGNET FÜR	1.4935 X20CrMoWV12-1, 1.4922 X20CrMoV12-1, 1.4923 X22CrMoV12-1, 1.4913 X19CrMoVNb11-1 (Turbotherm, 20 MVNb), 1.4931 GX22CrMoV12-1
ZULASSUNGEN	
SCHWEISSPOSITIONEN	
(%)	
MECHANISCHE GÜTEWERTE	
RÜCKTROCKNUNG	Not required
GAS ACC. EN ISO 14175	