




CEWELD AA M CrMo2

TYPE	Seamless metal core wire for heat and creep resistant applications.																			
ANWENDUNGEN	Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.																			
EIGENSCHAFTEN	Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.																			
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: E90C-B3 H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo2 M M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.28: E90C-B3 H4	EN ISO	17634-A: T CrMo2 M M21 3 H5	F-nr	6	FM	3											
AWS	A 5.28: E90C-B3 H4																			
EN ISO	17634-A: T CrMo2 M M21 3 H5																			
F-nr	6																			
FM	3																			
GEEIGNET FÜR	<p>2,25% Cr, 1% Mo 1.7015, 1.7131, 1.7147, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7383, 1.7385, 1.7707, 1.8075 10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,</p> <p>ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820</p>																			
ZULASSUNGEN	CE																			
SCHWEISSPOSITIONEN																				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.7</td> <td>0.015</td> <td>0.015</td> <td>2.3</td> <td>1.1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.08	0.4	0.7	0.015	0.015	2.3	1.1					
C	Si	Mn	P	S	Cr	Mo														
0.08	0.4	0.7	0.015	0.015	2.3	1.1														
MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> <th>0°C</th> </tr> </thead> <tbody> <tr> <td>675°C- 705°C 1h</td> <td>580</td> <td>750</td> <td>20</td> <td>100</td> <td>70</td> <td>90</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	RT	-20°C	0°C	675°C- 705°C 1h	580	750	20	100	70	90	HRc
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness									
		RT	-20°C	0°C																
675°C- 705°C 1h	580	750	20	100	70	90	HRc													
RÜCKTROCKNUNG	Not required																			
GAS ACC. EN ISO 14175	M21																			



CEWELD AA M CrMo2

AA M CRM02 1,0MM

Packaging	KG/unit	EanCode
K-300	16	8720663423498

AA M CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423504