



# CEWELD AA B CrMo1

| TYPE  | Medium alloyed flux-cored wire for CO2 and M 21 with basic slag.( Type CrMo1, B2)  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
|---|--|----------------|-------------------------|----------------------|-----------------------------|-------------------------|--------------------|----------|-------------------------|-----|---------------|-------|-------|-----|-----|--|-----|
| APPLICATIONS                                | Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| PROPERTIES                                  | Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for the economic processing on high-temperature resistant CrMo-steels up to 550 °C. X-ray-proof seams with negligible formation of spatter.   |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| CLASSIFICATION                              | <table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-B2M H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo1 B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>  | AWS            | A 5.29: E80T5-B2M H4    | EN ISO               | 17634-A: T CrMo1 B M21 3 H5 | F-nr                    | 6                  | FM       | 4                       |     |               |       |       |     |     |  |     |
| AWS   | A 5.29: E80T5-B2M H4   |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| EN ISO                                      | 17634-A: T CrMo1 B M21 3 H5  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| F-nr  | 6  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| FM  | 4  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| SUITABLE FOR                                | <p><b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b></p> <p>1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V</p> <p>ASTM A 182 Gr. F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12</p> |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| APPROVALS                                   | CE   |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| WELDING POSITIONS                           |  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1"> <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>0.05</td> <td>0.3</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>1.1</td> <td>0.5</td> </tr> </tbody> </table>   | C              | Si                      | Mn                   | P                           | S                       | Cr                 | Mo       | 0.05                    | 0.3 | 1.2           | 0.015 | 0.015 | 1.1 | 0.5 |  |     |
| C   | Si   | Mn             | P                       | S                    | Cr                          | Mo                      |                    |          |                         |     |               |       |       |     |     |  |     |
| 0.05  | 0.3  | 1.2            | 0.015                   | 0.015                | 1.1                         | 0.5                     |                    |          |                         |     |               |       |       |     |     |  |     |
| MECHANICAL PROPERTIES                       | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>690°C±15°C 2h</td> <td>485</td> <td>650</td> <td>25</td> <td colspan="2">80</td> <td>HRc</td> </tr> </tbody> </table>  | Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%)          | Impact Energy (J) ISO-V |                    | Hardness | RT                      |     | 690°C±15°C 2h | 485   | 650   | 25  | 80  |  | HRc |
| Heat Treatment                              | R <sub>P0,2</sub> (MPa)  |                |                         |                      |                             | R <sub>m</sub> (MPa)    | A <sub>5</sub> (%) |          | Impact Energy (J) ISO-V |     | Hardness      |       |       |     |     |  |     |
|   |  | RT             |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| 690°C±15°C 2h                               | 485  | 650            | 25                      | 80                   |                             | HRc                     |                    |          |                         |     |               |       |       |     |     |  |     |
| REDRYING                                    | Not required   |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |
| GAS ACC. EN ISO 14175                       | M21  |                |                         |                      |                             |                         |                    |          |                         |     |               |       |       |     |     |  |     |



# CEWELD AA B CrMo1

AA B CRM01 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663405340 |