



# CEWELD AA R CrMo1

**TYPE** Seamless rutile core wire with slag support for heat and creep resistant steels. (Type CrMo1, B2)

**APPLICATIONS** Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.

**PROPERTIES** Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of CrMo-steels up to 550°C.

**CLASSIFICATION**

AWS	A 5.29: E81T1-B2M H4
EN ISO	17634-A: T CrMo1 P M21 1 H5
F-nr	6
FM	3

**SUITABLE FOR** **Typ 1Cr0,5Mo, ISO 15608: ~5,1**  
 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  
 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

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Cr	Mo
0.06	0.3	1	0.015	0.015	1.1	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
675°C- 705°C 1h	540	620	20	70	50	HRc

**REDRYING** Not required

**GAS ACC.** EN ISO 14175