



CEWELD AA B CrMo2

TYPE Medium alloyed flux-cored wire for M21 with basic slag.

APPLICATIONS Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.

PROPRIÉTÉS Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.

CLASSIFICATION

AWS	A 5.29: E80T5-B2M H4
EN ISO	17634-A: T CrMo2 B M21 3 H5
F-nr	6
FM	4

CONVIENT POUR **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,
 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

AGRÉMENTS CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.05	0.3	1.2	0.015	0.015	2.5	1

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					RT	0°C	-20°C	
	675°C- 705°C 2h	490	620	24	120	80	60	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



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AA B CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388