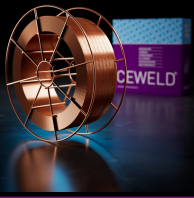


# CEWELD AA B CrMo1

|   |   |                             |                      |                    |                         |     |          |
|---|---|-----------------------------|----------------------|--------------------|-------------------------|-----|----------|
| TYPE  | Medium alloyed flux-cored wire for CO2 and M 21 with basic slag.  |                             |                      |                    |                         |     |          |
| APPLICATIONS                                | Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.   |                             |                      |                    |                         |     |          |
| PROPRIÉTÉS                                  | 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                              | AWS   | A 5.29: E80T5-B2M H4        |                      |                    |                         |     |          |
|   | EN ISO  | 17634-A: T CrMo1 B M21 3 H5 |                      |                    |                         |     |          |
|   | F-nr  | 6                           |                      |                    |                         |     |          |
|   | FM  | 4                           |                      |                    |                         |     |          |
| CONVIENT POUR                               | <b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b><br>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<br>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 |                             |                      |                    |                         |     |          |
| 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                   | 1.1 | 0.5      |
| PROPRIÉTÉS MÉCANIQUES                       | Heat Treatment  | R <sub>P0,2</sub> (MPa)     | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |     | Hardness |
|   | 690°C±15°C 2h   | 485                         | 650                  | 25                 | RT                      |     | HRc      |
| ETUVAGE                                     | 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 |