



# CEWELD S2 CrMo1

**TYPE** Submerged Arc wire for welding temperature resistant boiler steels and base metals.

**APPLICATIONS** Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.

**PROPRIÉTÉS** Submerged arc welding wire for high temperature creep resistant 1.25%Cr 0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Fluxes FL 180 and FL 155

**CLASSIFICATION**

AWS	A 5.23: EB2
EN ISO	24598-A: S CrMo1
W.Nr.	1.7346
F-nr	6
FM	3

**CONVIENT POUR** **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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Mo
0.1	0.25	0.95	0.01	0.01	1.2	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
				RT	-20°C	
690°C±15°C 3h	490	600	22	100	50	HRc

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S2 CrMo1

S2 CRM01 2,0MM

Packaging	KG/unit	EanCode
K-415	20	8720663404725

S2 CRM01 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404732

S2 CRM01 3,2MM

Packaging	KG/unit	EanCode
Drum	300	8720663405906
K-415	25	8720663404749

S2 CRM01 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404756