




# CEWELD AA B CrMo1

TYPE	Medium alloyed flux-cored wire for CO <sub>2</sub> and M 21 with basic slag.						
ANWENDUNGEN	Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	AWS	A 5.29: E80T5-B2M H4					
	EN ISO	17634-A: T CrMo1 B M21 3 H5					
	F-nr	6					
	FM	4					
GEEIGNET FÜR	<b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b> 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						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN							
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
MECHANISCHE GÜTEWERTE	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
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175	M21						



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AA B CRM01 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405340