



CEWELD SG CrMo2

| TYPE | Verkupferter Schweißdraht zum Schweißen kriech- und Wasserstoffbeständiger Stähle. P21- und P22-Stählen (CrMo2, B3). | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|-----|---------------|-----|-----|----|----|--|-----|
| ANWENDUNGEN | CEWELD® SG CrMo2 weist im vergüteten und angelassenen Zustand ein bainitisches Gefüge auf. Es wird für die Verarbeitung von hochwarmfesten Stählen in den Bereichen Hochdruckkesselbau, Offshore, Reparatur, Bau, Pipelines, Rohre usw. verwendet. | | | | | | | | | | | | | | | | |
| EIGENSCHAFTEN | CEWELD® SG CrMo2 ist ein extrem leicht zu schweißender Draht mit hervorragenden Schweißeigenschaften. Schweißbar mit Co2 und Mischgas. Geeignet für warmfeste Anwendungen bei Arbeitstemperaturen bis zu 600 °C. | | | | | | | | | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 90S-G</td> </tr> <tr> <td>EN ISO</td> <td>21952-A: G CrMo2Si</td> </tr> <tr> <td>W.Nr.</td> <td>1.7384</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table> | AWS | A 5.28: ER 90S-G | EN ISO | 21952-A: G CrMo2Si | W.Nr. | 1.7384 | F-nr | 6 | FM | 3 | | | | | | |
| AWS | A 5.28: ER 90S-G | | | | | | | | | | | | | | | | |
| EN ISO | 21952-A: G CrMo2Si | | | | | | | | | | | | | | | | |
| W.Nr. | 1.7384 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 3 | | | | | | | | | | | | | | | | |
| GEEIGNET FÜR | <p>2,25% Cr, 1% Mo 1.7015, 1.7131, 1.7147, 1.7258, 1.7262, 1.7276, 1.7281, 1.7337, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7382, 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, G19CrMo9-10, 16CrMo9-3, 11CrMo9-10, 10CrMo11</p> <p>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</p> | | | | | | | | | | | | | | | | |
| ZULASSUNGEN | CE | | | | | | | | | | | | | | | | |
| SCHWEISSPOSITIONEN | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.6</td> <td>0.9</td> <td>2.5</td> <td>1</td> </tr> </tbody> </table> | C | Si | Mn | Cr | Mo | 0.08 | 0.6 | 0.9 | 2.5 | 1 | | | | | | |
| C | Si | Mn | Cr | Mo | | | | | | | | | | | | | |
| 0.08 | 0.6 | 0.9 | 2.5 | 1 | | | | | | | | | | | | | |
| MECHANISCHE GÜTEWERTE | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>720°C±15°C 2h</td> <td>420</td> <td>520</td> <td>23</td> <td colspan="2">80</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | RT | | 720°C±15°C 2h | 420 | 520 | 23 | 80 | | HRc |
| Heat Treatment | R _{P0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | RT | | | | | | | | | | | | | | | |
| 720°C±15°C 2h | 420 | 520 | 23 | 80 | | HRc | | | | | | | | | | | |
| RÜCKTROCKNUNG | Nicht erforderlich | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | |



CEWELD SG CrMo2

SG CRM02 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405913 |

SG CRM02 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405944 |
| D-100 | 1 | 8720663405920 |

SG CRM02 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405951 |