



CEWELD SACW CrMo1V

TYPE High- basicity flux-cored wire for submerged-arc welding. (Typ CrMo1V, 1.7745)

ANWENDUNGEN CEWELD® SACW CrMo1V is a basic cored wire with Excellent weld puddle manipulation. Low spatter loss, easy slag removal. Extremely crack resistant. Suitable for economic welding of CrMoV-steels up to 550 °C. With Flux CEWELD FL155

EIGENSCHAFTEN Foundries, production welding

KLASSIFIKATION

| | |
|--------|-------------------------|
| AWS | A 5.23: G (~EB2V) |
| EN ISO | 24598-A: ST G (~CrMo1V) |
| W.Nr. | ~1.7745 |
| F-nr | 6 |
| FM | 4 |

GEEIGNET FÜR **Typ 1Cr0,5Mo,V ISO 15608: ~5,1**
 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733
 13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4,
 G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10
 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

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Mo | V |
|------|------|------|------|------|------|-----|-----|------|
| 0.12 | 0.25 | 0.85 | 0.02 | 0.02 | 1.25 | 0.3 | 1.1 | 0.25 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| 690°C±15°C 6h | 550 | 700 | 20 | 70 | | HRc |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175