



CEWELD E 8013-B2

TYPE	Cr and Mo-alloyed rutile low hydrogen coated electrode. (Type CrMo)1	
ANWENDUNGEN	Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers	
EIGENSCHAFTEN	Rutile stick electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating.	
KLASSIFIKATION	AWS	A 5.5: E 8013-G
	EN ISO	3580-A: E CrMo1 R 12
	F-nr	4
	FM	3

GEEIGNET FÜR **Typ 1Cr 0,5Mo, 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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.1	0.3	0.6	0.02	0.02	1.1	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					RT	
	660°C- 700°C 2h	380	540	22	55	HRc

RÜCKTROCKNUNG 400°C / 1 hr

GAS ACC. EN ISO 14175