CEWELD AA B CrMo2

certilas® THE FILLER METAL SPECIALIST

TYPE	Medium alloyed flux-cored wire for M21 with basic slag.
APPLICATIONS	Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.
PROPERTIES	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.

CLASSIFICATION

AWS	A 5.29: E80T5-B2M H4
EN ISO	17634-A: T CrMo2 B M21 3 H5
F-nr	6
FM	4

SUITABLE FOR

2,25% Cr, 1% Mo
1.7015, 1.7131, 1.7147, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 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,

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

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.05	0.3	1.2	0.015	0.015	2.5	1

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				RT	0°C	-20°C	
675°C- 705°C 2h	490	620	24	120	80	60	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M21

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AA B CRMO2 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388