



CEWELD AA B CrMo1

TYPE	Medium alloyed flux-cored wire for CO ₂ and M 21 with basic slag.(Type CrMo1, B2)																
APPLICATIONS	Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.																
PROPERTIES	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.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-B2M H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo1 B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.29: E80T5-B2M H4	EN ISO	17634-A: T CrMo1 B M21 3 H5	F-nr	6	FM	4								
AWS	A 5.29: E80T5-B2M H4																
EN ISO	17634-A: T CrMo1 B M21 3 H5																
F-nr	6																
FM	4																
SUITABLE FOR	<p>Typ 1Cr0,5Mo, ISO 15608: ~5,1</p> <p>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</p> <p>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</p>																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.3</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>1.1</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.05	0.3	1.2	0.015	0.015	1.1	0.5		
C	Si	Mn	P	S	Cr	Mo											
0.05	0.3	1.2	0.015	0.015	1.1	0.5											
MECHANICAL PROPERTIES	<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>690°C±15°C 2h</td> <td>485</td> <td>650</td> <td>25</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		690°C±15°C 2h	485	650	25	80		HRc
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT															
690°C±15°C 2h	485	650	25	80		HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21																



CEWELD AA B CrMo1

AA B CRM01 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405340