



# CEWELD AA B Mo

**TYPE** High-basic seamless flux-cored wire for welding creep resistant steels under M21

**APPLICATIONS** Steel and vessel construction, boiler works, mechanical engineering and pipework.

**PROPERTIES** Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).

**CLASSIFICATION**

|        |                           |
|--------|---------------------------|
| AWS    | A 5.36: E80T5-M21P4-A1-H4 |
| EN ISO | 17634-A: T Mo B M21 3 H5  |
| F-nr   | 6                         |
| FM     | 4                         |

**SUITABLE FOR** **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**  
 1.5415, 1.0481, 1.0482  
**15 Mo3, 16Mo3**, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300  
 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;  
 API 5 L B, X42, X52, X60, X65

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

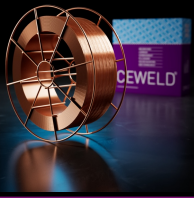
| C     | Si    | Mn   | Cr    | Ni    | Mo    | Cu    | Nb    |
|-------|-------|------|-------|-------|-------|-------|-------|
| 0.073 | 0.353 | 1.08 | 0.025 | 0.052 | 0.412 | 0.078 | 0.005 |

**MECHANICAL PROPERTIES**

| Heat Treatment  | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                 |                         |                      |                    | -20°C                   | -40°C |          |
| As Welded       | 510                     | 620                  | 24                 | 80                      | 75    | HRc      |
| 605°C- 645°C 1h | 520                     | 620                  | 25                 | 60                      | 55    | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA B MO

AA B MO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423207 |