



CEWELD AA MMo

TYPE Seamless metal core wire without slag with M21, for heat and creep resistant applications. 0.5% Mo. (Type Mo M, E81 T15)

APPLICATIONS CEWELD® AA MMo produces a weld metal alloyed with 0.5 % Mo. CEWELD® AA MMo can also be used for heat-treated welds. The range of applications extends from joint welding of high-temperature steels and cast steels to joint welding of high-strength structural steels, fine-grained structural steels and pipeline steels with yield strengths of up to 460 MPa. The main areas of application are tank and steel construction, mechanical engineering, boiler and pipeline construction.

PROPERTIES CEWELD® AA MMo is characterised by high performance, good weldability, smooth and clean weld seam and low spatter losses and is suitable for robotic applications. Ideal for short arc and spray arc welding with excellent gap bridging capability for root pass welding. Highly efficient design for economical welding of Mo steels up to 500 °C (932 °F). Thanks to the seamless manufacturing process, the hydrogen content is below 3 ml/100 weld metal even after long periods of storage.

CLASSIFICATION

| | |
|--------|---|
| AWS | A 5.28: E80C-G H4, A 5.36: E81T15-M21P4-A1-H4 |
| EN ISO | 17634-A: T Mo M M21 1 H5 |
| F-nr | 6 |
| FM | 3 |

SUITABLE FOR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 (~3.1)**
 1.0481, 1.0482, 1.5415,
15Mo3, 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 | P | S | Mo |
|------|-----|-----|-------|-------|-----|
| 0.05 | 0.7 | 1.2 | 0.015 | 0.015 | 0.5 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | -20°C | -40°C | |
| 570°C- 620°C 1h | 515 | 620 | 26 | 120 | 100 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA MMO

AA MMO 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| K-300 | 16 | 8720663423511 |