

# CEWELD SG CrMoV6

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                         |                                               |    |                         |                      |        |          |      |      |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|----|-------------------------|----------------------|--------|----------|------|------|
| TYPE                                        | Solid wire CrMoV6 for welding similar type of steels. (Air 9117 - 15CDV6)                                                                                                                                                                                                                                                                                                                               |                                               |    |                         |                      |        |          |      |      |
| TOEPASSINGEN                                | CEWELD® SG CrMoV6 is applicable for use in the aerospace and motorsports industries and also in the repair of some tool steels. According AIR 9117, LN 9425 an EN 4334.                                                                                                                                                                                                                                 |                                               |    |                         |                      |        |          |      |      |
| EIGENSCHAPPEN                               | CEWELD® SG CrMoV6 (EN 4334: FE-WL1806 (15CrMnMoV5-4-9-3) wire is used for welding matching, and similar, composition base materials. <b>The weld deposit from Typ 15CrMoV6 provides high strength. Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.</b> |                                               |    |                         |                      |        |          |      |      |
| CLASSIFICATIE                               | DIN                                                                                                                                                                                                                                                                                                                                                                                                     | 4334 FE-WL1806 (15CrMnMoV5-4-9-3)             |    |                         |                      |        |          |      |      |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                   | 1.7734                                        |    |                         |                      |        |          |      |      |
| GESCHIKT VOOR                               | 1.7734                                                                                                                                                                                                                                                                                                                                                                                                  | 15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12, 15CDV6, |    |                         |                      |        |          |      |      |
| GOEDKEURINGEN                               | CE                                                                                                                                                                                                                                                                                                                                                                                                      |                                               |    |                         |                      |        |          |      |      |
| LASPOSITIES                                 | <div></div>                                                         |                                               |    |                         |                      |        |          |      |      |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                       | Si                                            | Mn | P                       | S                    | Cr     | Mo       | V    | Fe   |
|                                             | 0.14                                                                                                                                                                                                                                                                                                                                                                                                    | 0.15                                          | 1  | 0.008                   | 0.008                | 1.4    | 0.9      | 0.22 | Rem. |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                          |                                               |    | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |      |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                               |                                               |    | 850                     | 1100                 | 10     | HRc      |      |      |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                            |                                               |    |                         |                      |        |          |      |      |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                     |                                               |    |                         |                      |        |          |      |      |

# CEWELD SG CrMoV6

SG CRMov6 1,2 MMMM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720682051696 |