



CEWELD AA B CrMo2

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, A 5.36: E80T5-M21PY-B2-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	PA PB PC							
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)	R _m (MPa)	A ₅ (%)	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 CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388