CEWELD AA M CrMo1

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless metal core wire without slag, for heat and creep resistant applications. (Type CrMo1, B2)

APPLICATIONS

CEWELD M CrMo1 is a metal powder cored wire for CrMo1 steels.
The main areas of application are single and multi-pass welding in boiler, pressure vessel, pipework, steam boiler and steam turbine construction.

PROPERTIES

CEWELD M CrMo1 has good arc ignition even with a cold wire tip and is well suited for robotic applications. Ideal for short arc and spray welding. It has excellent gap bridging properties in root pass welding. Economical series welding of CrMo steels up to 550°C (1022°F). Due to the seamless manufacturing process, the hydrogen content is less than 3 ml/100 g of weld metal even after prolonged storage in the unconditioned state.

CLASSIFICATION

AWS	A 5.28: E80C-B2 H4, A 5.36: E81T15-M21P4-B2-H4
EN ISO	17634-A: T CrMo1 M M21 1 H5
F-nr	6
FM	3

SUITABLE FOR

1 %Cr 0,5% Mo, ISO 15608: ~5,1 (0,75 % < Cr < 1,5 % und Mo < 0,7 %)
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
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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.06	0.3	1.2	0.015	0.01	1.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
675°C- 705°C 1h	500	630	21	80	55	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA M CrMo1

AA M CRMO1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403032