



# CEWELD S2 CrMo1

**TYPE** Submerged Arc wire for welding temperature resistant boiler steels and base metals.( Type CrMo1, B2)

**APPLICATIONS** Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.

**PROPERTIES** Submerged arc welding wire for high temperature creep resistant 1.25%Cr 0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Fluxes FL 180 and FL 155

**CLASSIFICATION**

|        |                  |
|--------|------------------|
| AWS    | A 5.23: EB2      |
| EN ISO | 24598-A: S CrMo1 |
| W.Nr.  | 1.7346           |
| F-nr   | 6                |
| FM     | 3                |

**SUITABLE FOR** **Typ 1Cr0,5Mo, ISO 15608: ~5,1**  
 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 THE FILLER METAL (%) | C   | Si   | Mn   | P    | S    | Cr  | Mo  |
|---------------------------------------------------|-----|------|------|------|------|-----|-----|
|                                                   | 0.1 | 0.25 | 0.95 | 0.01 | 0.01 | 1.2 | 0.5 |

| 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 |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                       |                |                         |                      |                    | RT                      | -20°C |          |
|                       | 690°C±15°C 3h  | 490                     | 600                  | 22                 | 100                     | 50    | HRc      |

**REDRYING** Not required

**GAS ACC.** EN ISO 14175



# CEWELD S2 CrMo1

## S2 CRM01 2,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 20      | 8720663404725 |

## S2 CRM01 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404732 |

## S2 CRM01 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 300     | 8720663405906 |
| K-415     | 25      | 8720663404749 |

## S2 CRM01 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404756 |