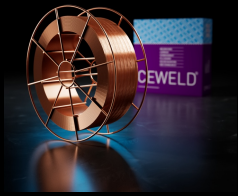




CEWELD AA MMo

TYPE	Seamless metal core wire without slag with M21, for heat and creep resistant applications.						
APPLICATIONS	Vessel and steel construction, mechanical engineering boiler and pipe work.						
PROPRIÉTÉS	Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production enviroments and Mo-steels up to 500 °C (932 °F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.						
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					
CONVIENT POUR	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						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE	PAPBPCPDPEPFPG						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Mo	
	0.05	0.7	1.2	0.015	0.015	0.5	
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
	570°C- 620°C 1h	515	620	26	-20°C	-40°C	HRc
ETUVAGE	Not required						
GAS ACC. EN ISO 14175	M21						



CEWELD AA MMO

AA MMO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423511