



CEWELD SACW CrMo1V

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

High- basicity flux-cored wire for submerged-arc welding. (Typ CrMo1V, 1.7745)

CEWELD® SACW CrMo1V is a basic cored wire with Excellent weld puddle manipulation. Low spatter loss, easy slag removal. Extremely crack resistant. Suitable for economic welding of CrMoV-steels up to 550 °C. With Flux CEWELD FL155

Foundries, production welding

AWS

EN ISO

W.Nr.

F-nr

FM

A 5.23: G (~EB2V)

24598-A: ST G (~CrMo1V)

~1.7745

6

4

Typ 1Cr0,5Mo,V ISO 15608: ~5,1

1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733

13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10

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

PA

PB

C	Si	Mn	P	S	Cr	Ni	Mo	V
0.12	0.25	0.85	0.02	0.02	1.25	0.3	1.1	0.25

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
690°C±15°C 6h	550	700	20	70		HRc

Not required