



CEWELD SG CrMo1

TYPE Copper coated welding wire for welding creep and hydrogen-resistant steels.

ANWENDUNGEN High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.

EIGENSCHAFTEN Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Suitable to offer creep resistance for working temperatures up to 550° Celsius. The wire has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications.

KLASSIFIKATION

AWS	A 5.28: ER 80S-G
EN ISO	21952-A: G CrMo1Si
W.Nr.	1.7339
F-nr	6
FM	3

GEEIGNET FÜR **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. F11 / 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 ; A 199; A200; A 387 Gr A11 / 12

ZULASSUNGEN CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.09	0.6	0.99	0.006	0.011	1.18	0.49

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
620°C±15°C 1h	400	560	22	80		HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 M21



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SG CRM01 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405821
D-100	1	8720663405852
D-200	5	8720663405838
D-200	3	8720663405845

SG CRM01 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405869

SG CRM01 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405876
Drum	250	8720663405890

SG CRM01 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405883

SG CRM01 4,0MM

Packaging	KG/unit	EanCode
Drum	250	8720663405937