



# CEWELD SG CrMo1

**TYPE** Copper coated welding wire for welding creep and hydrogen-resistant steels.( Type CrMo1, B2 )

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

**PROPERTIES** 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.

**CLASSIFICATION**

AWS	A 5.28: ER 80S-G
EN ISO	21952-A: G CrMo1Si
W.Nr.	1.7339
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. 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

**APPROVALS** CE

**WELDING POSITIONS**

**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

**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		
620°C±15°C 1h	400	560	22	80		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD SG CrMo1

## 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