



# CEWELD AA MMo0

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 environments 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				
	EN ISO	17634-A: T Mo M M21 1 H5				
	F-nr	6				
	FM	3				
CONVIENT POUR	<b>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3</b> 1.5415, 1.0481, 1.0482 <b>15 Mo3, 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</b> 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						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Mo
	0.05	0.7	1.2	0.015	0.015	0.5
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V -20°C	Hardness
	As Welded	500	640	22	55	HRc
ETUVAGE	Not required					
GAS ACC. EN ISO 14175	M21					



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AA MMO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423511