CEWELD AA M CrMo2

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless metal core wire for heat and creep resistant applications.

TOEPASSINGEN

Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.

EIGENSCHAPPEN

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 of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.

CLASSIFICATIE

AWS	A 5.28: E90C-B3 H4
EN ISO	17634-A: T CrMo2 M M21 3 H5
F-nr	6
FM	3

GESCHIKT VOOR

2,25% Cr, 1% Mo
1.7015, 1.7131, 1.7147, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7383, 1.7385, 1.7707, 1.8075
10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,

ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820

GOEDKEURINGEN

CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.4	0.7	0.015	0.015	2.3	1.1

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				RT	-20°C	0°C	
675°C- 705°C 1h	580	750	20	100	70	90	HRc

HERDROGEN

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA M CrMo2

AA M CRMO2 1,0MM

Packaging	KG/unit	EanCode
K-300	16	8720663423498

AA M CRMO2 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423504