



CEWELD AA R CrMo1

TYPE	Seamless rutile core wire with slag support for heat and creep resistant steels								
ANWENDUNGEN	Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.								
EIGENSCHAFTEN	Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of CrMo-steels up to 550°C.								
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E81T1-B2M H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo1 P M21 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.29: E81T1-B2M H4	EN ISO	17634-A: T CrMo1 P M21 1 H5	F-nr	6	FM	3
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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. 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

ZULASSUNGEN CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.06	0.3	1	0.015	0.015	1.1	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-20°C	
	675°C- 705°C 1h	540	620	20	70	50	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175