CEWELD SG CrMo1 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper coated welding rod for welding creep and hydrogen–resistant steels. (Type CrMo1, B2)

APPLICATIONS

CEWELD® SG CRMo1 Tig is suitable for boiler and pipe construction steels with 1.25% Cr and 0.5% Mo as well as for welding heat-treatable and case-hardening steels.
The main areas of application are: High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.

PROPERTIES

CEWELD® SG CRMo1 Tig is extreme easy to weld with excellent welding properties. Suitable to offer creep resistance for working temperatures up to 550 °C. The rod has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant application

CLASSIFICATION

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

SUITABLE FOR

Typ 1Cr0,5Mo, ISO 15608: ~5,1
1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728
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	Cr	Mo
0.09	0.6	1	1.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-40°C	
690°C±15°C 1h	460	560	22	80	47	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1

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SG CRMO1 TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411396

SG CRMO1 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411402

SG CRMO1 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411419

SG CRMO1 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411426

SG CRMO1 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411433