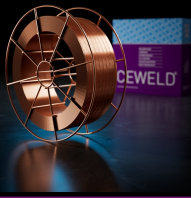


# CEWELD SG CrMo1

TYPE	Copper coated welding wire for welding creep and hydrogen-resistant steels.( Type CrMo1, B2 )																					
APPLICATIONS	<p>CEWELD® SG CRMo1 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.</p> <p>The main areas of application are: High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.</p>																					
PROPERTIES	<p>CEWELD® SG CRMo1 is Extreme easy to weld with excellent welding properties. Suitable to offer creep resistance for working temperatures up to 550 °C. The wire has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor (X&lt; 10 ppm) for temper embrittlement resistant application</p>																					
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	<p><b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b>            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</p>																					
APPROVALS	CE																					
WELDING POSITIONS																						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.09</td> <td>0.6</td> <td>0.99</td> <td>0.006</td> <td>0.011</td> <td>1.18</td> <td>0.49</td> </tr> </tbody> </table>						C	Si	Mn	P	S	Cr	Mo	0.09	0.6	0.99	0.006	0.011	1.18	0.49		
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MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>620°C±15°C 1h</td> <td>400</td> <td>560</td> <td>22</td> <td>90</td> <td>55</td> <td>HRc</td> </tr> </tbody> </table>						Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT	-20°C	620°C±15°C 1h	400	560	22	90	55	HRc
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				RT	-20°C																	
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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