



# CEWELD AA B CrMo2

<b>TYPE</b>	Medium alloyed flux-cored wire for M21 with basic slag.							
<b>APPLICATIONS</b>	Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.							
<b>PROPERTIES</b>	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.							
<b>CLASSIFICATION</b>	AWS	A 5.29: E80T5-B2M H4						
	EN ISO	17634-A: T CrMo2 B M21 3 H5						
	F-nr	6						
	FM	4						
<b>SUITABLE FOR</b>	<b>2,25% Cr, 1% Mo</b>							
	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							
<b>APPROVALS</b>	CE							
<b>WELDING POSITIONS</b>								
<b>TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)</b>	C	Si	Mn	P	S	Cr	Mo	
	0.05	0.3	1.2	0.015	0.015	2.5	1	
<b>MECHANICAL PROPERTIES</b>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness
	675°C- 705°C 2h	490	620	24	RT	0°C	-20°C	HRc
<b>REDRYING</b>	Not required							
<b>GAS ACC. EN ISO 14175</b>	M21							



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AA B CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388