



CEWELD S2 CrMo1

TYPE Submerged Arc wire for welding temperature resistant boiler steels and base metals.(Type CrMo1, B2)

APPLICATIONS Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.

PROPERTIES Submerged arc welding wire for high temperature creep resistant 1.25%Cr 0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Fluxes FL 180 and FL 155

CLASSIFICATION

AWS	A 5.23: EB2
EN ISO	24598-A: S CrMo1
W.Nr.	1.7346
F-nr	6
FM	3

SUITABLE FOR **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

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.1	0.25	0.95	0.01	0.01	1.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
690°C±15°C 3h	490	600	22	100	50	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



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S2 CRM01 2,0MM

Packaging	KG/unit	EanCode
K-415	20	8720663404725

S2 CRM01 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663404732

S2 CRM01 3,2MM

Packaging	KG/unit	EanCode
Drum	300	8720663405906
K-415	25	8720663404749

S2 CRM01 4,0MM

Packaging	KG/unit	EanCode
K-415	25	8720663404756