CEWELD AA R Mo

certilas® THE FILLER METAL SPECIALIST

TYPE	seamless micro alloyed rutile core wire with rapidly solidifying slag for M21
APPLICATIONS	Steel and vessel construction, mechanical engineering and pipework.
PROPERTIES	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 Mo-steels up to 500°C.

CLASSIFICATION

AWS	A 5.29: E81T1-A1M H4
EN ISO	17634-A: T MoL P M21 1 H5
F-nr	6
FM	3

SUITABLE FOR

Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3
1.5415, 1.0481, 1.0482
15 Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;
API 5 L B, X42, X52, X60, X65

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Mo
0.05	0.7	1.3	0.015	0.015	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
As Welded	500	610	22	60	35	HRc
580°C±15°C 1h	480	610	22	60	35	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M21

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AA R MO 1,2MM

Packaging	KG/unit	EanCode
D-200	5	8720663423740
K-300	16	8720663423757