



# CEWELD E 8013-B2

**TYPE** Cr and Mo-alloyed rutile low hydrogen coated electrode. (Type CrMo)1

**APPLICATIONS** Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers

**PROPERTIES** Rutile stick electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating.

**CLASSIFICATION**

AWS	A 5.5: E 8013-G
EN ISO	3580-A: E CrMo1 R 12
F-nr	4
FM	3

**SUITABLE FOR** **Typ 1Cr 0,5Mo, 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 WELD METAL (%)**

C	Si	Mn	P	S	Cr	Mo
0.1	0.3	0.6	0.02	0.02	1.1	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
660°C- 700°C 2h	380	540	22	55		HRc

**REDRYING** 400°C / 1 hr

**GAS ACC. EN ISO 14175**