



# CEWELD AA MMo0

**TYPE** Seamless metal core wire without slag with M21, for heat and creep resistant applications.

**APPLICATIONS** Vessel and steel construction, mechanical engineering boiler and pipe work.

**PROPRIÉTÉS** Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production environments and Mo-steels up to 500 °C (932 °F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

**CLASSIFICATION**

AWS	A 5.28: E80C-G H4
EN ISO	17634-A: T Mo M M21 1 H5
F-nr	6
FM	3

**CONVIENT POUR** **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**  
 1.5415, 1.0481, 1.0482  
**15Mo3, 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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Mo
0.05	0.7	1.2	0.015	0.015	0.5

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
570°C- 620°C 1h	515	620	26	120	100	HRc

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA MMO

AA MMO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423511