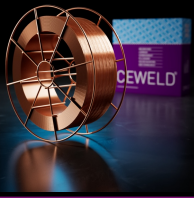


CEWELD AA M CrMo2

TYPE	Seamless metal core wire for heat and creep resistant applications.																									
APPLICATIONS	Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.																									
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 of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.																									
CLASSIFICATION	AWS	A 5.28: E90C-B3 H4																								
	EN ISO	17634-A: T CrMo2 M M21 3 H5																								
	F-nr	6																								
	FM	3																								
CONVIENT POUR	2,25% Cr, 1% Mo 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																									
AGRÉMENTS	CE																									
POSITIONS DE SOUDAGE																										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.7</td> <td>0.015</td> <td>0.015</td> <td>2.3</td> <td>1.1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.08	0.4	0.7	0.015	0.015	2.3	1.1											
C	Si	Mn	P	S	Cr	Mo																				
0.08	0.4	0.7	0.015	0.015	2.3	1.1																				
PROPRIÉTÉS MÉCANIQUES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> <th>0°C</th> </tr> </thead> <tbody> <tr> <td>675°C- 705°C 1h</td> <td>580</td> <td>750</td> <td>20</td> <td>100</td> <td>70</td> <td>90</td> <td>HRc</td> </tr> </tbody> </table>							Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	RT	-20°C	0°C	675°C- 705°C 1h	580	750	20	100	70	90	HRc
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness																			
				RT	-20°C	0°C																				
675°C- 705°C 1h	580	750	20	100	70	90	HRc																			
ETUVAGE	Not required																									
GAS ACC. EN ISO 14175	M21																									



CEWELD AA M CrMo2

AA M CRM02 1,0MM

Packaging	KG/unit	EanCode
K-300	16	8720663423498

AA M CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423504