CEWELD AA M CrMo1V

certilas® THE FILLER METAL SPECIALIST

TYPE	Seamless metal cored wire for M21 shielding gas. (Typ CrMo1V, 1.7745)
APPLICATIONS	CEWELD® AA MCrMo1V is a metal flux cored wire with excellent weld pool handling. The main areas of application are: Foundries, production welding
PROPRIÉTÉS	CEWELD® AA MCrMo1V shows low spatter loss, extremely crack resistant. Suitable for economical welding of CrMoV steels up to 550 °C. Due to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g weld metal even after prolonged storage. Good gap bridging properties. In the current range (PF) of 85 - 175 A, suitable for vertical piercing seams.

CLASSIFICATION

AWS	A 5.28: ER80T15-GM2M H4, A 5.36: E80T15-M21PY-G-H4
EN ISO	17634-A: T Z M M 1 H5
W.Nr.	~1.7745
F-nr	6
FM	4

CONVIENT POUR

1%Cr 0,5%Mo, ISO 15608: ~5,1 (0,75 % < Cr < 1,5 % und Mo < 0,7 % und ~0,3% V)
1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733
13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10
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

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V
0.1	0.3	0.9	0.015	0.015	1.1	0.3	1	0.25

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
690°C±15°C 6h	550	700	20	70	HRc

ETUVAGE Not required

Heat Treatment: Quenched and tempered (30 min at 950° C / oil and 16 h at 700°C furnace cooling to 300° C) Rp0,2 >440 MPa Rm 590-780 MPa A5 > 15 Quenched and tempered (30 min at 950° C / air and 16 h at 700°C furnace cooling to 300° C) Rp0,2 >440 MPa Rm 590-780 MPa A5 > 15

GAS ACC. EN ISO 14175 M21