



# CEWELD AA B CrMo1

TYPE	Medium alloyed flux-cored wire for CO <sub>2</sub> and M 21 with basic slag.( Type CrMo1, B2)																
APPLICATIONS	Steam boiler, pressure vessels, apparatus construction, mechanical engineering, pipe work, steam turbine construction, foundries.																
PROPERTIES	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for the economic processing on high-temperature resistant CrMo-steels up to 550 °C. X-ray-proof seams with negligible formation of spatter.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-B2M H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo1 B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.29: E80T5-B2M H4	EN ISO	17634-A: T CrMo1 B M21 3 H5	F-nr	6	FM	4								
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SUITABLE FOR	<p><b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b></p> <p>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</p> <p>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</p>																
APPROVALS	CE																
WELDING POSITIONS																	
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>0.05</td> <td>0.3</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>1.1</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.05	0.3	1.2	0.015	0.015	1.1	0.5		
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690°C±15°C 2h	485	650	25	80		HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M21																



# CEWELD AA B CrMo1

AA B CRM01 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405340