



CEWELD AA B Mo

TYPE High-basic seamless flux-cored wire for welding creep resistant steels under M21

APPLICATIONS Steel and vessel construction, boiler works, mechanical engineering and pipework.

PROPERTIES Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).

CLASSIFICATION

AWS	A 5.36: E80T5-M21P4-A1-H4
EN ISO	17634-A: T Mo B M21 3 H5
F-nr	6
FM	4

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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb
0.073	0.353	1.08	0.025	0.052	0.412	0.078	0.005

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	510	620	24	80	75	HRc
605°C- 645°C 1h	520	620	25	60	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



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AA B MO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423207