



CEWELD AA M CrMo1

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

APPLICATIONS Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.

PROPRIÉTÉS Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use in the field short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production environments and CrMo-steels up to 550 °C (1022°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-B2 H4 |
| EN ISO | 17634-A: T CrMo1 M M21 1 H5 |
| F-nr | 6 |
| FM | 3 |

CONVIENT POUR **Typ 1Cr0,5Mo, ISO 15608: ~5,1**
 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
 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 CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Cr | Mo |
|------|-----|-----|-------|------|-----|-----|
| 0.06 | 0.3 | 1.2 | 0.015 | 0.01 | 1.1 | 0.5 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | RT | -20°C | |
| 675°C- 705°C 1h | 500 | 630 | 21 | 80 | 55 | HRc |

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



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AA M CRM01 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663403032 |