



CEWELD SG CrMo1

| TYPE | Massief verkoperde lasdraad voor het lassen van kruip- en waterstofbestendig staal (type CrMo1, B2) | | | | | | | | | | | | | | | | |
|---|--|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|-------|---------------|-------|-------|------|------|----|-----|
| TOEPASSINGEN | Hogedruk ketelstaal, offshore, reparatie, constructie, pijpleidingen, buizen enz. | | | | | | | | | | | | | | | | |
| EIGENSCHAPPEN | Extreem gemakkelijk te lassen met uitstekende laseigenschappen. Wereldwijd gerespecteerde kwaliteit met gecontroleerde gieting en helix voor half- en halfautomatische toepassingen. Geschikt om kruipweerstand te bieden bij werktemperaturen tot 550° Celsius. De draad heeft een laag gehalte aan tramp-elementen (bijv. Sn, As, Sb en P) en heeft een lage Bruscato Factor (X< 10 ppm) voor toepassingen die bestand zijn tegen verbrossing. | | | | | | | | | | | | | | | | |
| CLASSIFICATIE | <table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 80S-G</td> </tr> <tr> <td>EN ISO</td> <td>21952-A: G CrMo1Si</td> </tr> <tr> <td>W.Nr.</td> <td>1.7339</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table> | AWS | A 5.28: ER 80S-G | EN ISO | 21952-A: G CrMo1Si | W.Nr. | 1.7339 | F-nr | 6 | FM | 3 | | | | | | |
| AWS | A 5.28: ER 80S-G | | | | | | | | | | | | | | | | |
| EN ISO | 21952-A: G CrMo1Si | | | | | | | | | | | | | | | | |
| W.Nr. | 1.7339 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 3 | | | | | | | | | | | | | | | | |
| GESCHIKT VOOR | <p>Typ 1Cr0,5Mo, ISO 15608: ~5,1 1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728 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. F11 / 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 ; A 199; A200; A 387 Gr A11 / 12</p> | | | | | | | | | | | | | | | | |
| GOEDKEURINGEN | CE | | | | | | | | | | | | | | | | |
| LASPOSITIES | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER 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>0.09</td> <td>0.6</td> <td>0.99</td> <td>0.006</td> <td>0.011</td> <td>1.18</td> <td>0.49</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Cr | Mo | 0.09 | 0.6 | 0.99 | 0.006 | 0.011 | 1.18 | 0.49 | | |
| C | Si | Mn | P | S | Cr | Mo | | | | | | | | | | | |
| 0.09 | 0.6 | 0.99 | 0.006 | 0.011 | 1.18 | 0.49 | | | | | | | | | | | |
| MECHANISCHE WAARDEN | <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="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>620°C±15°C 1h</td> <td>400</td> <td>560</td> <td>22</td> <td>90</td> <td>55</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 | 620°C±15°C 1h | 400 | 560 | 22 | 90 | 55 | HRc |
| Heat Treatment | R _{p0,2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | RT | -20°C | | | | | | | | | | | | | | |
| 620°C±15°C 1h | 400 | 560 | 22 | 90 | 55 | HRc | | | | | | | | | | | |
| HERDROGEN | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | M21 | | | | | | | | | | | | | | | | |



CEWELD SG CrMo1

SG CRM01 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405821 |
| D-100 | 1 | 8720663405852 |
| D-200 | 5 | 8720663405838 |
| D-200 | 3 | 8720663405845 |

SG CRM01 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405869 |

SG CRM01 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405876 |
| Drum | 250 | 8720663405890 |

SG CRM01 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663405883 |

SG CRM01 4,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Drum | 250 | 8720663405937 |