



CEWELD AA B CrMo1

TYPE	Medium alloyed flux-cored wire for CO2 and M 21 with basic slag.(Type CrMo1, B2)						
APPLICATIONS	CEWELD® AA B CrMo1 is a seamless basic flux-cored wire electrode for CrMo1 steels. The main areas of application are single- and multi-layer welds in boiler, pressure vessel, pipeline, steam boiler, and steam turbine construction.						
PROPERTIES	CEWELD® AA B CrMo1 has low spatter loss and easy slag removal. Suitable for economical welding of CrMo1 steels up to 550 °C. Due to the seamless manufacturing process, the hydrogen content remains below HD<3ml/100g weld metal even after long storage						
CLASSIFICATION	AWS	A 5.29: E80T5-B2M H4, A 5.36: E80T5-M21PY-B2-H4					
	EN ISO	17634-A: T CrMo1 B M21 3 H5					
	F-nr	6					
	FM	4					
SUITABLE FOR	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						
APPROVALS	CE						
WELDING POSITIONS	 PA  PB  PC						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.05	0.3	1.2	0.015	0.015	1.1	0.5
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	690°C±15°C 2h	485	650	25	RT		HRc
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						



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AA B CRM01 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405340