



# CEWELD AA R Mo

**TYPE** seamless micro alloyed rutile core wire with rapidly solidifying slag for M21

**APPLICATIONS** Steel and vessel construction, mechanical engineering and pipework.

**PROPERTIES** Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C.

**CLASSIFICATION**

|        |                                                 |
|--------|-------------------------------------------------|
| AWS    | A 5.29: E81T1-A1M H4, A 5.36: E81T1-M21PY-A1-H4 |
| EN ISO | 17634-A: T MoL P M21 1 H5                       |
| F-nr   | 6                                               |
| FM     | 3                                               |

**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 (%)**

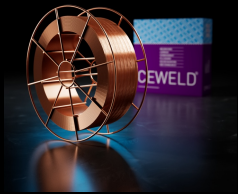
| C    | Si  | Mn  | P     | S     | Mo  |
|------|-----|-----|-------|-------|-----|
| 0.05 | 0.7 | 1.3 | 0.015 | 0.015 | 0.5 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                |                         |                      |                    | RT                      | -20°C |          |
| As Welded      | 500                     | 610                  | 22                 | 60                      | 35    | HRc      |
| 580°C±15°C 1h  | 480                     | 610                  | 22                 | 60                      | 35    | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA R Mo

AA R MO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| D-200     | 5       | 8720663423740 |
| K-300     | 16      | 8720663423757 |