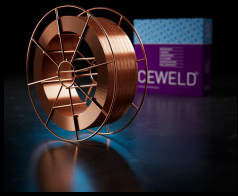




# CEWELD SG CrMo2

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                      |                      |                    |                         |          |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|----------------------|--------------------|-------------------------|----------|
| TYPE                                              | GMAW wire for welding creep and hydrogen –resistant P21 and P22 steels.(CrMo2, B3)                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |          |
| APPLICATIONS                                      | CEWELD® SG CrMo2 exhibits a bainitic microstructure in the tempered and tempered condition. It is used for processing high-temperature steels in High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.                                                                                                                                                                                                                                                                                                                         |                                      |                      |                    |                         |          |
| PROPERTIES                                        | CEWELD® SG CrMo2 is an extremely easy-to-weld wire with excellent welding properties. It typically contains 2.25 % chromium and 1.0 % molybdenum.<br>Weldable with Co2 and mixed gas. Suitable for heat-resistant applications at working temperatures up to 600 °C..                                                                                                                                                                                                                                                                                        |                                      |                      |                    |                         |          |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | A 5.28: ER 90S-G, A 5.28: ~ER 90S-B3 |                      |                    |                         |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 21952-A: G CrMo2Si                   |                      |                    |                         |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 1.7384                               |                      |                    |                         |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 6                                    |                      |                    |                         |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 3                                    |                      |                    |                         |          |
| SUITABLE FOR                                      | <b>2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % &lt; Cr &lt; 3,5 % und 0,7%</b><br>1.7015, 1.7131, 1.7147, 1.7276, 1.7281,1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7383, 1.7385, 1.7707, 1.8075<br>10CrMo9-10, 10CrMo11, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,<br><br>ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820 |                                      |                      |                    |                         |          |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |          |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                      |                    |                         |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Si                                   | Mn                   | Cr                 | Mo                      |          |
|                                                   | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 0.6                                  | 0.9                  | 2.5                | 1                       |          |
| 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 |
|                                                   | 720°C±15°C 2h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 420                                  | 520                  | 23                 | 80                      | HRc      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                      |                      |                    |                         |          |
| GAS ACC. EN ISO 14175                             | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                      |                      |                    |                         |          |



# CEWELD SG CrMo2

## SG CRM02 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663405913 |

## SG CRM02 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663405944 |
| D-100     | 1       | 8720663405920 |

## SG CRM02 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663405951 |