



CEWELD E 8013-B2

TYPE Cr and Mo-alloyed rutile low hydrogen coated electrode. (Type CrMo)1

APPLICATIONS Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers

PROPERTIES Rutile stick electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating.

CLASSIFICATION

AWS	A 5.5: E 8013-G
EN ISO	3580-A: E CrMo1 R 12
F-nr	4
FM	3

SUITABLE FOR **Typ 1Cr 0,5Mo, 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



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.1	0.3	0.6	0.02	0.02	1.1	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
675°C- 705°C 2h	500	600	22	60	HRc

REDRYING 400°C / 1 hr

GAS ACC. EN ISO 14175