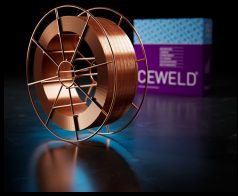




# CEWELD AA M CrMo2

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |                         |                       |                         |       |     |          |
|--------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-------------------------|-----------------------|-------------------------|-------|-----|----------|
| TYPE                                                   | Seamless metal core wire for heat and creep resistant applications.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                             |                         |                       |                         |       |     |          |
| APPLICATIONS                                           | Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                             |                         |                       |                         |       |     |          |
| PROPRIÉTÉS                                             | Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.                                                                                                                                                                                                                                                                   |                             |                         |                       |                         |       |     |          |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.28: E90C-B3 H4          |                         |                       |                         |       |     |          |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 17634-A: T CrMo2 M M21 3 H5 |                         |                       |                         |       |     |          |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                           |                         |                       |                         |       |     |          |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 3                           |                         |                       |                         |       |     |          |
| CONVIENT POUR                                          | 2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%<br>1.7015, 1.7131, 1.7147, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7383, 1.7385, 1.7707, 1.8075<br>10CrMo9.10, 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                                                                                                                                                                                         |                             |                         |                       |                         |       |     |          |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                             |                         |                       |                         |       |     |          |
| POSITIONS DE SOUDAGE                                   | <div>PA</div> <div>PB</div> <div>PC</div> <div>PD</div> <div>PE</div> <div>PF</div> <div>PG</div> |                             |                         |                       |                         |       |     |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                          | Mn                      | P                     | S                       | Cr    | Mo  |          |
|                                                        | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.4                         | 0.7                     | 0.015                 | 0.015                   | 2.3   | 1.1 |          |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub><br>(MPa)  | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       |     | Hardness |
|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |                         |                       | RT                      | -20°C | 0°C |          |
|                                                        | 675°C- 705°C 1h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 580                         | 750                     | 20                    | 100                     | 70    | 90  | HRc      |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                             |                         |                       |                         |       |     |          |
| GAS ACC. EN ISO 14175                                  | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                             |                         |                       |                         |       |     |          |



# CEWELD AA M CrMo2

AA M CRM02 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423498 |

AA M CRM02 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423504 |