



# CEWELD AA M CrMo1V

**TYPE** Seamless metal cored wire for M21 shielding gas. (Typ CrMo1V, 1.7745)

**TOEPASSINGEN** CEWELD® AA MCrMo1V is a metal flux cored wire with excellent weld pool handling. The main areas of application are: Foundries, production welding

**EIGENSCHAPPEN** CEWELD® AA MCrMo1V shows low spatter loss, extremely crack resistant. Suitable for economical welding of CrMoV steels up to 550 °C. Due to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g weld metal even after prolonged storage. Good gap bridging properties. In the current range (PF) of 85 - 175 A, suitable for vertical piercing seams.

**CLASSIFICATIE**

|        |                                                    |
|--------|----------------------------------------------------|
| AWS    | A 5.28: ER80T15-GM2M H4, A 5.36: E80T15-M21PY-G-H4 |
| EN ISO | 17634-A: T Z M M 1 H5                              |
| W.Nr.  | ~1.7745                                            |
| F-nr   | 6                                                  |
| FM     | 4                                                  |

**GESCHIKT VOOR** **1%Cr 0,5%Mo, ISO 15608: ~5,1 (0,75 % < Cr < 1,5 % und Mo < 0,7 % und ~0,3% V)**  
 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733  
 13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4,  
 G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10  
 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

**GOEDKEURINGEN**

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si  | Mn  | P     | S     | Cr  | Ni  | Mo | V    |
|-----|-----|-----|-------|-------|-----|-----|----|------|
| 0.1 | 0.3 | 0.9 | 0.015 | 0.015 | 1.1 | 0.3 | 1  | 0.25 |

**MECHANISCHE WAARDEN**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
|                |                         |                      |                    | RT                      |          |
| 690°C±15°C 6h  | 550                     | 700                  | 20                 | 70                      | HRc      |

**HERDROGEN** Not required

Heat Treatment: Quenched and tempered ( 30 min at 950° C / oil and 16 h at 700°C furnace cooling to 300° C ) R<sub>p0,2</sub> >440 MPa R<sub>m</sub> 590-780 MPa A<sub>5</sub> > 15 Quenched and tempered ( 30 min at 950° C / air and 16 h at 700°C furnace cooling to 300° C ) R<sub>p0,2</sub> >440 MPa R<sub>m</sub> 590-780 MPa A<sub>5</sub> > 15

**GAS ACC. EN ISO 14175** M21