



CEWELD AA R CrMo1

TYPE Seamless rutile core wire with slag support for heat and creep resistant steels. (Type CrMo1, B2)

APPLICATIONS Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.

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 CrMo-steels up to 550°C.

CLASSIFICATION

AWS	A 5.29: E81T1-B2M H4
AWS	A 5.36: E81T1-M21PY-B2-H4
EN ISO	17634-A: T CrMo1 P M21 1 H5
F-nr	6
FM	3

SUITABLE FOR **Typ 1Cr0,5Mo, 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
0.06	0.3	1	0.015	0.015	1.1	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -20°C
675°C- 705°C /1h	540	620	20	70	50

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175