



CEWELD AA B CrMo2

TYPE	Medium alloyed flux-cored wire for M21 with basic slag.																	
APPLICATIONS	Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.																	
PROPERTIES	Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.																	
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.29: E80T5-B2M H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E80T5-M21PY-B2-H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T CrMo2 B M21 3 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.29: E80T5-B2M H4	AWS	A 5.36: E80T5-M21PY-B2-H4	EN ISO	17634-A: T CrMo2 B M21 3 H5	F-nr	6	FM	4							
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SUITABLE FOR	<p>2,25% Cr, 1% Mo 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 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,</p> <p>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</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.3</td> <td>1.2</td> <td>0.015</td> <td>0.015</td> <td>2.5</td> <td>1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.05	0.3	1.2	0.015	0.015	2.5	1			
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> </tr> <tr> <th>RT</th> <th>0°C</th> <th>-20°C</th> </tr> </thead> <tbody> <tr> <td>675°C- 705°C /2h</td> <td>490</td> <td>620</td> <td>24</td> <td>120</td> <td>80</td> <td>60</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V			RT	0°C	-20°C	675°C- 705°C /2h	490	620	24	120	80	60
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		RT	0°C	-20°C														
675°C- 705°C /2h	490	620	24	120	80	60												
REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M21																	



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AA B CRM02 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663405388