

CEWELD SACW CrMo2

TYPE	High- basicity flux-cored wire for submerged-arc welding. Type P22						
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. Flux FL 150 of FL 160 can be used in combination with this wire.						
CLASSIFICATION	AWS	A 5.23: F9P2-ECB3-B3					
	EN ISO	24598-A: S T Z CrMo2 FB					
	F-nr	6					
	FM	4					
SUITABLE FOR	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, 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						
APPROVALS	CE						
WELDING POSITIONS	 PA  PB  PC						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.09	0.25	0.9	0.015	0.015	2.3	1.1
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		
	675°C- 705°C /1h	560	640	20	RT		
					100		
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175							