



# CEWELD AA B Mo<sub>0</sub>

**TYPE** High-basic seamless flux-cored wire for welding creep resistant steels under M21

**APPLICATIONS** Steel and vessel construction, boiler works, mechanical engineering and pipework.

**PROPERTIES** Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).

**CLASSIFICATION**

AWS	A 5.36: E80T5-M21P4-A1-H4
AWS	A 5.29: E80T5-G H4
EN ISO	17634-A: T Mo B M21 3 H5
F-nr	6
FM	4

**SUITABLE FOR** **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**  
 1.5415, 1.0481, 1.0482  
**15 Mo<sub>3</sub>, 16Mo<sub>3</sub>**, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300  
 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;  
 API 5 L B, X42, X52, X60, X65

**APPROVALS** CE

**WELDING POSITIONS**



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

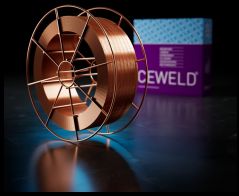
C	Si	Mn	Cr	Ni	Mo	Cu	Nb
0.073	0.353	1.08	0.025	0.052	0.412	0.078	0.005

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
As Welded / 605°C- 645°C /1h	510 520	620 620	24 25	80 60	75 55

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** M21



# CEWELD AA B Mo

AA B MO 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663423207