CEWELD AA B Mo

certilas® THE FILLER METAL SPECIALIST

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 Mo3, 16Mo3, 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	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C
As Welded /	510	620	24	80	75
605°C- 645°C /1h	520	620	25	60	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