



CEWELD AA B CrMo1

TYPE	Medium alloyed flux-cored wire for CO ₂ and M 21 with basic slag.(Type CrMo1, B2)														
APPLICATIONS	CEWELD® AA B CrMo1 is a seamless basic flux-cored wire electrode for CrMo1 steels. The main areas of application are single- and multi-layer welds in boiler, pressure vessel, pipeline, steam boiler, and steam turbine construction.														
PROPERTIES	CEWELD® AA B CrMo1 has low spatter loss and easy slag removal. Suitable for economical welding of CrMo1 steels up to 550 °C. Due to the seamless manufacturing process, the hydrogen content remains below HD<3ml/100g weld metal even after long storage														
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 CrMo1 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 CrMo1 B M21 3 H5	F-nr	6	FM	4				
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F-nr	6														
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SUITABLE FOR	<p>Typ 1Cr0,5Mo, ISO 15608: ~5,1</p> <p>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</p> <p>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</p>														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; text-align: center;"> <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>1.1</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Mo	0.05	0.3	1.2	0.015	0.015	1.1	0.5
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690°C±15°C /2h	485	650	25	RT 80											
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M21														



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AA B CRM01 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663405340