CEWELD AA M CrMo2

certilas® THE FILLER METAL SPECIALIST

TYPE

CrMo-alloyed seamless metal powder cored wire for heat and creep resistant applications (CrMo2, B3)

APPLICATIONS

CEWELD® AA MCrMo2 is a CrMo-alloyed seamless metal powder cored wire for heat and creep resistant applications.
Main applications are in the field of Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction

PROPERTIES

CEWELD® AA MCrMo2 has good arc ignition even with a cold wire tip and is suitable for robotic applications. It is ideal for short arc and spray arc welding and has excellent gap bridging properties for root pass welding. A highly efficient grade for the economical welding of high-temperature steels and hydrogen pressure resistant 2¼Cr1Mo steels. Thanks to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g of weld metal even after prolonged storage in the unconditioned state.

CLASSIFICATION

AWS	A 5.28: E90C-B3 H4
EN ISO	17634-A: T CrMo2 M M21 3 H5
F-nr	6
FM	3

SUITABLE FOR

2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%
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

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.08	0.4	0.7	0.015	0.015	2.3	1.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	-20°C	0°C
580°C /1h	580	750	20	100	70	90

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21

CEWELD AA M CrMo2

AA M CRMO2 1,0MM

Type	KG/unit	EANCode
K-300	16	8720663423498

AA M CRMO2 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663423504