



CEWELD AA M CrMo1

TYPE Seamless metal core wire without slag with M21, for heat and creep resistant applications. (Type CrMo1, B2)

APPLICATIONS Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.

PROPERTIES Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use in the field short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production environments and CrMo-steels up to 550 °C (1022°F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

CLASSIFICATION

AWS	A 5.28: E80C-B2 H4
AWS	A 5.36: E81T15-M21P4-B2-H4
EN ISO	17634-A: T CrMo1 M M21 1 H5
F-nr	6
FM	3

SUITABLE FOR **Typ 1Cr0,5Mo, ISO 15608: ~5,1**
 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
 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

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.06	0.3	1.2	0.015	0.01	1.1	0.5

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	RT	Impact Energy (J) ISO-V
	675°C- 705°C /1h	500	630	21	80	-20°C 55

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21



CEWELD AA M CrMo1

AA M CRM01 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663403032