CEWELD AA MMo

certilas® THE FILLER METAL SPECIALIST

TYPE

Seamless metal core wire without slag with M21, for heat and creep resistant applications. 0.5% Mo. (Type Mo M, E81 T15)

APPLICATIONS

CEWELD® AA MMo produces a weld metal alloyed with 0.5 % Mo. CEWELD® AA MMo can also be used for heat-treated welds. The range of applications extends from joint welding of high-temperature steels and cast steels to joint welding of high-strength structural steels, fine-grained structural steels and pipeline steels with yield strengths of up to 460 MPa.
The main areas of application are tank and steel construction, mechanical engineering, boiler and pipeline construction.

PROPERTIES

CEWELD® AA MMo is characterised by high performance, good weldability, smooth and clean weld seam and low spatter losses and is suitable for robotic applications. Ideal for short arc and spray arc welding with excellent gap bridging capability for root pass welding. Highly efficient design for economical welding of Mo steels up to 500 °C (932 °F). Thanks to the seamless manufacturing process, the hydrogen content is below 3 ml/100 weld metal even after long periods of storage.

CLASSIFICATION

AWS	A 5.28: E80C-G H4
AWS	A 5.36: E81T15-M21P4-A1-H4
EN ISO	17634-A: T Mo M M21 1 H5
F-nr	6
FM	3

SUITABLE FOR

Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 (~3.1)
1.0481, 1.0482, 1.5415,
15Mo3, 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	P	S	Mo
0.05	0.7	1.2	0.015	0.015	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C
570°C- 620°C /1h	515	620	26	120	100

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21

CEWELD AA MMo

AA MMO 1,2MM

Type	KG/unit	EANCode
K-300	16	8720663423511