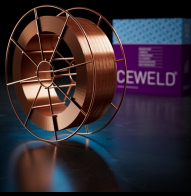




# CEWELD SG CrMo2

TYPE	GMAW wire for welding creep and hydrogen –resistant P21 and P22 steels.(CrMo2, B3)																
APPLICATIONS	CEWELD® SG CrMo2 exhibits a bainitic microstructure in the tempered and tempered condition. It is used for processing high-temperature steels in High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc.																
PROPERTIES	CEWELD® SG CrMo2 have aExtreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi–automatic applications. Weldable with Co2 and Mix gas. Suitable for creep resistant service for working temperatures up to 600 °C.																
CLASSIFICATION	AWS	A 5.28: ER 90S-G															
	AWS	A 5.28: ~ER 90S-B3															
	EN ISO	21952-A: G CrMo2Si															
	F-nr	6															
	FM	3															
	W.Nr.	1.7384															
SUITABLE FOR	<b>2,25% Cr, 1% Mo</b> 1.7015, 1.7131, 1.7147, 1.7258, 1.7262, 1.7276, 1.7281, 1.7337, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7382, 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, G19CrMo9-10, 16CrMo9-3, 11CrMo9-10, 10CrMo11  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 THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cr</td> <td style="width: 25%;">Mo</td> </tr> <tr> <td>0.08</td> <td>0.6</td> <td>0.9</td> <td>2.5</td> <td>1</td> </tr> </table>		C	Si	Mn	Cr	Mo	0.08	0.6	0.9	2.5	1					
C	Si	Mn	Cr	Mo													
0.08	0.6	0.9	2.5	1													
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 10%;">R<sub>P0,2</sub></td> <td style="width: 10%;">R<sub>m</sub></td> <td style="width: 10%;">A<sub>5</sub></td> <td style="width: 45%;">Impact Energy (J) ISO-V</td> </tr> <tr> <td>720°C±15°C /2h</td> <td>MPa</td> <td>MPa</td> <td>(%)</td> <td>RT</td> </tr> <tr> <td></td> <td>420</td> <td>520</td> <td>23</td> <td>80</td> </tr> </table>		Heat Treatment	R <sub>P0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V	720°C±15°C /2h	MPa	MPa	(%)	RT		420	520	23	80
Heat Treatment	R <sub>P0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V													
720°C±15°C /2h	MPa	MPa	(%)	RT													
	420	520	23	80													
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M21																



# CEWELD SG CrMo2

SG CRM02 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663405913

SG CRM02 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663405944
D-100	1	8720663405920

SG CRM02 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663405951