



CEWELD SACW CrMo1

TYPE	Seamless copper coated wire Type11														
APPLICATIONS	These steels are used for creep resisting applications up to ~550 °C.														
PROPERTIES	SACW CrMo1 is a cored wire for high temperature creep resistant 1.25%Cr-0.5%Mo ferritic steel, i.e. P11/P12 Typical with FL 155 Flux or FL 160														
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.23: EB2</td> </tr> <tr> <td>EN ISO</td> <td>24598-A: S T CrMo1</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.23: EB2	EN ISO	24598-A: S T CrMo1	F-nr	6	FM	4						
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EN ISO	24598-A: S T CrMo1														
F-nr	6														
FM	4														
SUITABLE FOR	<p>Type 1Cr 0,5Mo, ISO 15608: ~ 5.1 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 13CrMo4-5, 15CrMo5, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5 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	No Approvals Found														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>P</td> <td>S</td> <td>Cr</td> <td>Mo</td> </tr> <tr> <td>0.1</td> <td>0.2</td> <td>0.8</td> <td>0.015</td> <td>0.015</td> <td>1.2</td> <td>0.5</td> </tr> </table>	C	Si	Mn	P	S	Cr	Mo	0.1	0.2	0.8	0.015	0.015	1.2	0.5
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>RT</th> <th>-20°C</th> </tr> <tr> <td>580°C /1h</td> <td>470</td> <td>570</td> <td>22</td> <td>100</td> <td>50</td> </tr> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		RT	-20°C	580°C /1h	470	570	22	100	50
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		RT	-20°C												
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REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175															