



CEWELD AA M CrMo1V

TYPE	Seamless metal cored wire for M21 shielding gas. (Typ CrMo1V, 1.7745)																		
APPLICATIONS	Foundries, production welding																		
PROPERTIES	CEWELD® AA MCrMo1V is a metal cored wire with Excellent weld puddle manipulation. Low spatter loss, without slag. Extremely crack resistant. Suitable for economic welding of CrMoV-steels up to 550 °C. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition. Good gap bridging properties. In the current range (PF) of 85 - 175 A for vertical up seams suitable.																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER80T15-GM2M H4</td> </tr> <tr> <td>AWS</td> <td>A 5.36: E80T15-M21PY-G-H4</td> </tr> <tr> <td>EN ISO</td> <td>17634-A: T Z M M 1 H5</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> <tr> <td>W.Nr.</td> <td>~1.7745</td> </tr> </table>	AWS	A 5.28: ER80T15-GM2M H4	AWS	A 5.36: E80T15-M21PY-G-H4	EN ISO	17634-A: T Z M M 1 H5	F-nr	6	FM	4	W.Nr.	~1.7745						
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SUITABLE FOR	<p>Typ 1Cr0,5Mo,V ISO 15608: ~5,1</p> <p>1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733 13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10 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"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>V</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.3</td> <td>0.9</td> <td>0.015</td> <td>0.015</td> <td>1.1</td> <td>0.3</td> <td>1</td> <td>0.25</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	V	0.1	0.3	0.9	0.015	0.015	1.1	0.3	1	0.25
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REDRYING TEMPERATURE	Not required																		
GAS ACCORDING EN 14175	M21																		