



# CEWELD E 8013-B2

TYPE	Cr and Mo-alloyed rutile low hydrogen coated electrode. (Type CrMo)1														
APPLICATIONS	Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers														
PROPERTIES	Rutile stick electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating.														
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.5: E 8013-G</td></tr><tr><td>EN ISO</td><td>3580-A: E CrMo1 R 12</td></tr><tr><td>F-nr</td><td>4</td></tr><tr><td>FM</td><td>3</td></tr></table>							AWS	A 5.5: E 8013-G	EN ISO	3580-A: E CrMo1 R 12	F-nr	4	FM	3
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F-nr	4														
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SUITABLE FOR	<p><b>Typ 1Cr 0,5Mo, ISO 15608: ~5,1</b></p> <p>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,</p> <p>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</p> <p>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	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 0.1	Si 0.3	Mn 0.6	P 0.02	S 0.02	Cr 1.1	Mo 0.5								
ALL WELD MECHANICAL PROPERTIES	Heat Treatment 660°C- 700°C /2h	R <sub>P0,2</sub> MPa 380	Rm MPa 540	A5 (%) 22	Impact Energy (J) ISO-V RT 55										
REDRYING TEMPERATURE	400°C / 1 hr														
GAS ACCORDING EN 14175															