



CEWELD AA B CrMo2

TYPE

ANWENDUNGEN

EIGENSCHAFTEN

KLASSIFIKATION

GEEIGNET FÜR

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG

GAS ACC. EN ISO 14175

Medium alloyed flux-cored wire for M21 with basic slag.

Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.

Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.

AWS
EN ISO
F-nr
FM

A 5.29: E80T5-B2M H4, A 5.36: E80T5-M21PY-B2-H4
17634-A: T CrMo2 B M21 3 H5
6
4

2,25% Cr, 1% Mo
1.7015, 1.7131, 1.7147, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 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,

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

CE

PA

PB

PC

C	Si	Mn	P	S	Cr	Mo
0.05	0.3	1.2	0.015	0.015	2.5	1

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
				RT	0°C	-20°C	
675°C- 705°C 2h	490	620	24	120	80	60	HRc

Not required

M21



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AA B CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388