



CEWELD AA M CrMo1

TYPE	Seamless metal core wire without slag with M21, for heat and creep resistant applications						
ANWENDUNGEN	Construction of containers, boilers, machines and pipe work. Construction of steam boilers and steam turbines.						
EIGENSCHAFTEN	Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use in the field short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production enviroments and CrMo-steels up to 550 °C (1022°F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.						
KLASSIFIKATION	AWS	A 5.28: E80C-B2 H4, A 5.36: E81T15-M21P4-B2-H4					
	EN ISO	17634-A: T CrMo1 M M21 1 H5					
	F-nr	6					
	FM	3					
GEEIGNET FÜR	1 %Cr 0,5% Mo, ISO 15608: ~5,1 (0,75 % < Cr < 1,5 % und Mo < 0,7 %) 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, 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 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						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN	 PA  PB  PC  PD  PE  PF  PG						
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Cr	Mo
	0.06	0.3	1.2	0.015	0.01	1.1	0.5
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-20°C	
	675°C- 705°C 1h	500	630	21	80	55	HRc
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175	M21						



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AA M CRM01 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663403032