



CEWELD AA B CrMo2

TYPE	Medium alloyed flux-cored wire for M21 with basic slag.							
ANWENDUNGEN	Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.							
EIGENSCHAFTEN	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.							
KLASSIFIKATION	AWS	A 5.29: E80T5-B2M H4, A 5.36: E80T5-M21PY-B2-H4						
	EN ISO	17634-A: T CrMo2 B M21 3 H5						
	F-nr	6						
	FM	4						
GEEIGNET FÜR	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							
ZULASSUNGEN	CE							
SCHWEISSPOSITIONEN	 PA  PB  PC							
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Cr	Mo	
	0.05	0.3	1.2	0.015	0.015	2.5	1	
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	675°C- 705°C 2h	490	620	24	RT	0°C	-20°C	HRc
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	M21							



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AA B CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663405388