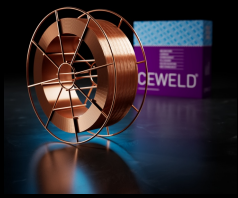




# CEWELD AA B Mo

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                               |                            |                         |                       |                         |       |          |
|--------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|----------------------------|-------------------------|-----------------------|-------------------------|-------|----------|
| TYPE                                                   | High-basic seamless flux-cored wire for welding creep resistant steels under M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                               |                            |                         |                       |                         |       |          |
| APPLICATIONS                                           | Steel and vessel construction, boiler works, mechanical engineering and pipework.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                               |                            |                         |                       |                         |       |          |
| PROPRIÉTÉS                                             | Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                               |                            |                         |                       |                         |       |          |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | A 5.36: E80T5-M21P4-A1-H4, A 5.29: E80T5-G H4 |                            |                         |                       |                         |       |          |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 17634-A: T Mo B M21 3 H5                      |                            |                         |                       |                         |       |          |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 6                                             |                            |                         |                       |                         |       |          |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 4                                             |                            |                         |                       |                         |       |          |
| CONVIENT POUR                                          | <b>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3</b><br>1.5415, 1.0481, 1.0482<br><b>15 Mo3, 16Mo3</b> , 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300<br>ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;<br>API 5 L B, X42, X52, X60, X65 |                                               |                            |                         |                       |                         |       |          |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                               |                            |                         |                       |                         |       |          |
| POSITIONS DE SOUDAGE                                   | <div>PAPBPC</div>                                                                                                                                                                                                                                                                                                                                                                                              |                                               |                            |                         |                       |                         |       |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Si                                            | Mn                         | Cr                      | Ni                    | Mo                      | Cu    | Nb       |
|                                                        | 0.073                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.353                                         | 1.08                       | 0.025                   | 0.052                 | 0.412                   | 0.078 | 0.005    |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                               | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                               |                            |                         |                       | -20°C                   | -40°C |          |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                               | 510                        | 620                     | 24                    | 80                      | 75    |          |
|                                                        | 605°C- 645°C 1h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                               | 520                        | 620                     | 25                    | 60                      | 55    | HRc      |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                               |                            |                         |                       |                         |       |          |
| GAS ACC. EN ISO 14175                                  | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                               |                            |                         |                       |                         |       |          |



# CEWELD AA B Mo

AA B MO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423207 |