



# CEWELD S2 CrMo1

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |        |                         |       |          |
|------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------|-------------------------|-------|----------|
| TYPE                                           | Submerged Arc wire for welding temperature resistant boiler steels and base metals.                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |        |                         |       |          |
| ANWENDUNGEN                                    | Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.                                                                                                                                                                                                                                                                                                                                                               |                         |                      |        |                         |       |          |
| EIGENSCHAFTEN                                  | Submerged arc welding wire for high temperature creep resistant 1.25%Cr 0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Fluxes FL 180 and FL 155                                                                                                                                                                                |                         |                      |        |                         |       |          |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | A 5.23: EB2             |                      |        |                         |       |          |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 24598-A: S CrMo1        |                      |        |                         |       |          |
|                                                | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 1.7346                  |                      |        |                         |       |          |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 6                       |                      |        |                         |       |          |
|                                                | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 3                       |                      |        |                         |       |          |
| GEEIGNET FÜR                                   | <b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b><br>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,<br>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<br>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                             | <div>  </div>                                                                                                                                                                                                                                                                     |                         |                      |        |                         |       |          |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Si                      | Mn                   | P      | S                       | Cr    | Mo       |
|                                                | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 0.25                    | 0.95                 | 0.01   | 0.01                    | 1.2   | 0.5      |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |        | RT                      | -20°C |          |
|                                                | 690°C±15°C 3h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 490                     | 600                  | 22     | 100                     | 50    | HRc      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |        |                         |       |          |
| GAS ACC. EN ISO 14175                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                         |                      |        |                         |       |          |



# CEWELD S2 CrMo1

## S2 CRM01 2,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 20      | 8720663404725 |

## S2 CRM01 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404732 |

## S2 CRM01 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 300     | 8720663405906 |
| K-415     | 25      | 8720663404749 |

## S2 CRM01 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404756 |