

CEWELD AA R Mo

TYPE seamless micro alloyed rutile core wire with rapidly solidifying slag for M21

APPLICATIONS Steel and vessel construction, mechanical engineering and pipework.

PROPERTIES Excellent weld puddle manipulation, superior out-of-position welding. Particularly suited for MAG orbital welding applications and all-position welding on ceramic backing. Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C.

CLASSIFICATION

AWS	A 5.29: E81T1-A1M H4, A 5.36: E81T1-M21PY-A1-H4
EN ISO	17634-A: T MoL P M21 1 H5
F-nr	6
FM	3

SUITABLE FOR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**
1.5415, 1.0481, 1.0482
15 Mo3, 16Mo3, 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
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;
API 5 L B, X42, X52, X60, X65

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

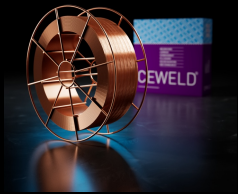
C	Si	Mn	P	S	Mo
0.05	0.7	1.3	0.015	0.015	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-20°C	
As Welded	500	610	22	60	35	HRc
580°C±15°C 1h	480	610	22	60	35	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



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AA R MO 1,2MM

Packaging	KG/unit	EanCode
D-200	5	8720663423740
K-300	16	8720663423757