



CEWELD AA M CrMo2

TYPE CrMo-alloyed seamless metal powder cored wire for heat and creep resistant applications (CrMo2, B3)

APPLICATIONS CEWELD® AA MCrMo2 is a CrMo-alloyed seamless metal powder cored wire for heat and creep resistant applications.
Main applications are in the field of Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction

PROPERTIES CEWELD® AA MCrMo2 has good arc ignition even with a cold wire tip and is suitable for robotic applications. It is ideal for short arc and spray arc welding and has excellent gap bridging properties for root pass welding. A highly efficient grade for the economical welding of high-temperature steels and hydrogen pressure resistant 2¼Cr1Mo steels. Thanks to the seamless manufacturing process, the hydrogen content is below 3 ml/100 g of weld metal even after prolonged storage in the unconditioned state.

CLASSIFICATION

AWS	A 5.28: E90C-B3 H4
EN ISO	17634-A: T CrMo2 M M21 3 H5
F-nr	6
FM	3

SUITABLE FOR **2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%**
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

APPROVALS CE

WELDING POSITIONS

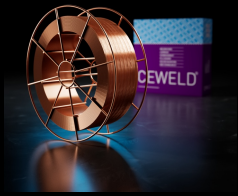


TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.08	0.4	0.7	0.015	0.015	2.3	1.1

MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
					RT	-20°C	0°C	
	675°C- 705°C 1h	580	750	20	100	70	90	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA M CrMo2

AA M CRM02 1,0MM

Packaging	KG/unit	EanCode
K-300	16	8720663423498

AA M CRM02 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423504