



CEWELD AA MMo

TYPE Seamless metal core wire without slag with M21, for heat and creep resistant applications.

APPLICATIONS Vessel and steel construction, mechanical engineering boiler and pipe work.

PROPRIÉTÉS Good arc restriking even with cold wire tip, suitable for robot applications. Ideal for use of short arc and spray arc. Excellent gap bridging for root welding. High-efficiency type for economic production environments and Mo-steels up to 500 °C (932 °F) . Due to the seamless production process the hydrogen content is below 3ml/100gr weld metal even after long storage in unconditioned condition.

CLASSIFICATION

AWS	A 5.28: E80C-G H4, A 5.36: E81T15-M21P4-A1-H4
EN ISO	17634-A: T Mo M M21 1 H5
F-nr	6
FM	3

CONVIENT POUR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 (~3.1)**
 1.0481, 1.0482, 1.5415,
15Mo3, 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

AGRÉMENTS CE

POSITIONS DE SOUDAGE

C	Si	Mn	P	S	Mo
0.05	0.7	1.2	0.015	0.015	0.5

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
570°C- 620°C 1h	515	620	26	120	100	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



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AA MMO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423511