CEWELD AA B CrMo1V

certilas® THE FILLER METAL SPECIALIST

TYPE

High basic flux-cored wire for CO2 and M21 shielding gas

ANWENDUNGEN

Foundries, production welding

EIGENSCHAFTEN

CEWELD® AA BCrMo1V is a basic cored wire with Excellent weld puddle manipulation. Low spatter loss, easy slag removal. Extremely crack resistant. Suitable for economic welding of CrMoV-steels up to 550 °C. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.

KLASSIFIKATION

AWS	A 5.29: E80T5-B2M H4, A 5.36: E80T5-M21P4-B2-H4
EN ISO	17634-A: T Z B M 4 H5
W.Nr.	~1.7745
F-nr	6
FM	4

GEEIGNET FÜR

Type 1Cr0,5Mo,V ISO 15608: ~5,1
1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733
13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10, 21CrMoV5-11, 26CrMoV5-11
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

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V
0.1	0.3	0.9	0.15	0.015	1.2	0.3	1.1	0.25

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
690°C±15°C 3h	500	620	20	70	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

M21

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AA B CRMO1V 1,2MM

Packaging	KG/unit	EanCode
BS-300	16	8720663423191