



CEWELD AA B Mo

TYPE	High-basic seamless flux-cored wire for welding creep resistant steels under M21
APPLICATIONS	Steel and vessel construction, boiler works, mechanical engineering and pipework.
PROPRIÉTÉS	Excellent weld puddle manipulation, Low spatter loss, easy slag removal. Suitable for economic welding of Mo-steels up to 500°C (932°F).
CLASSIFICATION	AWS A 5.36: E80T5-M21P4-A1-H4, A 5.29: E80T5-G H4 EN ISO 17634-A: T Mo B M21 3 H5 F-nr 6 FM 4

CONVIENT POUR	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
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AGRÉMENTS	CE
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POSITIONS DE SOUDAGE	
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ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Cr	Ni	Mo	Cu	Nb
	0.073	0.353	1.08	0.025	0.052	0.412	0.078	0.005

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-20°C	-40°C	
	As Welded	510	620	24	80	75	HRc
	605°C- 645°C 1h	520	620	25	60	55	HRc

ETUVAGE	Not required
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GAS ACC. EN ISO 14175	M21
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AA B MO 1,2MM

Packaging	KG/unit	EanCode
K-300	16	8720663423207