



# CEWELD S2 CrMo2

**TYPE** Submerged Arc wire for welding temperature resistant boiler steels and base metals.

**APPLICATIONS** Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.

**PROPRIÉTÉS** Submerged arc welding wire for high temperature creep resistant 2,45%Cr 1,0%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Recommended flux: FL 155

**CLASSIFICATION**

|        |                  |
|--------|------------------|
| AWS    | A 5.23: EB3      |
| EN ISO | 24598-A: S CrMo2 |
| F-nr   | 6                |
| FM     | 3                |

**CONVIENT POUR** **2,25% Cr, 1% Mo**  
 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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**

| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C   | Si   | Mn  | P    | S    | Cr   | Mo |
|------------------------------------------------------|-----|------|-----|------|------|------|----|
|                                                      | 0.1 | 0.25 | 0.6 | 0.01 | 0.01 | 2.45 | 1  |

| PROPRIÉTÉS MÉCANIQUES | Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                       |                |                         |                      |                    | RT                      | -20°C |          |
|                       | 690°C±15°C 3h  | 490                     | 600                  | 24                 | 100                     | 50    | HRc      |

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S2 CrMo2

S2 CRM02 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663404800 |

S2 CRM02 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663424303 |