



CEWELD AA M CrMo2

TYPE	Seamless metal core wire for heat and creep resistant applications.							
APPLICATIONS	Construction of containers, boilers, machines and pipe work. Steam boilers and turbines construction.							
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 of creep resistant steels and pressure-hydrogen-resistant 2¼Cr1Mo-steels. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage in unconditioned condition.							
CLASSIFICATION	AWS	A 5.28: E90C-B3 H4						
	EN ISO	17634-A: T CrMo2 M M21 3 H5						
	F-nr	6						
	FM	3						
CONVIENT POUR	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							
AGRÉMENTS	CE							
POSITIONS DE SOUDAGE	PA PB PC PD PE PF PG							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Cr	Mo	
	0.08	0.4	0.7	0.015	0.015	2.3	1.1	
PROPRIÉTÉS MÉCANIQUES	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
ETUVAGE	Not required							
GAS ACC. EN ISO 14175	M21							



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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