



# CEWELD SACW CrMo1V

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                            |                         |                       |                         |     |          |      |
|--------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------------|-------------------------|-----------------------|-------------------------|-----|----------|------|
| TYPE                                                   | High- basicity flux-cored wire for submerged-arc welding. (Typ CrMo1V, 1.7745)                                                                                                                                                                                                                                                                                                                       |                         |                            |                         |                       |                         |     |          |      |
| APPLICATIONS                                           | CEWELD® SACW CrMo1V 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. With Flux CEWELD FL155                                                                                                                                                                |                         |                            |                         |                       |                         |     |          |      |
| PROPRIÉTÉS                                             | Foundries, production welding                                                                                                                                                                                                                                                                                                                                                                        |                         |                            |                         |                       |                         |     |          |      |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                  | A 5.23: G (~EB2V)       |                            |                         |                       |                         |     |          |      |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                               | 24598-A: ST G (~CrMo1V) |                            |                         |                       |                         |     |          |      |
|                                                        | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                | ~1.7745                 |                            |                         |                       |                         |     |          |      |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                                                                                                 | 6                       |                            |                         |                       |                         |     |          |      |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                   | 4                       |                            |                         |                       |                         |     |          |      |
| CONVIENT POUR                                          | <b>Typ 1Cr0,5Mo,V ISO 15608: ~5,1</b><br>1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7745, 1.7706, 1.7733<br>13CrMo4-5, 15CrMo5, 15 CrMoV 5 10, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5, 24CrMoV5-5, G17CrMoV5-10<br>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 |                         |                            |                         |                       |                         |     |          |      |
| AGRÉMENTS                                              |                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                            |                         |                       |                         |     |          |      |
| POSITIONS DE SOUDAGE                                   |                                                                                                                                                                                                                                  |                         |                            |                         |                       |                         |     |          |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                    | Si                      | Mn                         | P                       | S                     | Cr                      | Ni  | Mo       | V    |
|                                                        | 0.12                                                                                                                                                                                                                                                                                                                                                                                                 | 0.25                    | 0.85                       | 0.02                    | 0.02                  | 1.25                    | 0.3 | 1.1      | 0.25 |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                       |                         | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |     | Hardness |      |
|                                                        | 690°C±15°C 6h                                                                                                                                                                                                                                                                                                                                                                                        |                         | 550                        | 700                     | 20                    | RT                      |     | HRc      |      |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                                                         |                         |                            |                         |                       |                         |     |          |      |
| GAS ACC. EN ISO 14175                                  |                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                            |                         |                       |                         |     |          |      |