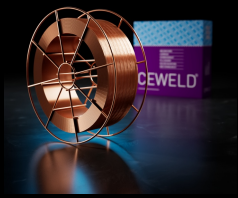




# CEWELD AA B Mo

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                               |                         |                      |                    |                         |       |          |
|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| TYPE                                        | Basisch gevulde naadloze lasdraad voor het lassen van kruipvaste staalsoorten                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                               |                         |                      |                    |                         |       |          |
| TOEPASSINGEN                                | Staal- en scheepsbouw, ketelbouw, machinebouw en pijpleidingen.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                               |                         |                      |                    |                         |       |          |
| EIGENSCHAPPEN                               | Uitstekend controleerbare druppelovergang, laag spatverlies, gemakkelijke slakverwijdering. Geschikt voor lassen van kruipvaststaal staal tot 500°C (932°F).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                               |                         |                      |                    |                         |       |          |
| CLASSIFICATIE                               | 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                                             |                         |                      |                    |                         |       |          |
| GESCHIKT VOOR                               | <b>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3</b><br>1.5415, 1.0481, 1.0482<br><b>15 Mo3, 16Mo3</b> , 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<br>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;<br>API 5 L B, X42, X52, X60, X65 |                                               |                         |                      |                    |                         |       |          |
| GOEDKEURINGEN                               | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                               |                         |                      |                    |                         |       |          |
| LASPOSITIES                                 | <div>  </div>                                                                                                                                                                                                                                                                                                                                                                                                  |                                               |                         |                      |                    |                         |       |          |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Si                                            | Mn                      | Cr                   | Ni                 | Mo                      | Cu    | Nb       |
|                                             | 0.073                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.353                                         | 1.08                    | 0.025                | 0.052              | 0.412                   | 0.078 | 0.005    |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                               | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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      |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                               |                         |                      |                    |                         |       |          |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                               |                         |                      |                    |                         |       |          |



# CEWELD AA B Mo

AA B MO 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-300     | 16      | 8720663423207 |