

# CEWELD SACW CrMo2

|              |                                                                                                                                                                                                                                                                                                 |
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| TYPE         | High- basicity flux-cored wire for submerged-arc welding. Type P22                                                                                                                                                                                                                              |
| APPLICATIONS | Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.                                                                                                                                      |
| PROPERTIES   | Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance. Flux FL 150 of FL 160 can be used in combination with this wire. |

|                |        |                         |
|----------------|--------|-------------------------|
| CLASSIFICATION | AWS    | A 5.23: F9P2-ECB3-B3    |
|                | EN ISO | 24598-A: S T Z CrMo2 FB |
|                | F-nr   | 6                       |
|                | FM     | 4                       |

|              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|--------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| SUITABLE FOR | <b>2,25% Cr, 1% Mo</b><br>1.7015, 1.7131, 1.7147, 1.7218, 1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7383, 1.7385, 1.7707, 1.8075<br>10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 25CrMo4, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,<br><br>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 |
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| APPROVALS | CE |
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| WELDING POSITIONS |    |
|-------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                             |      |      |     |       |       |     |     |
|---------------------------------------------|------|------|-----|-------|-------|-----|-----|
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C    | Si   | Mn  | P     | S     | Cr  | Mo  |
|                                             | 0.09 | 0.25 | 0.9 | 0.015 | 0.015 | 2.3 | 1.1 |

|                       |                 |                         |                      |                    |                         |          |
|-----------------------|-----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
| MECHANICAL PROPERTIES | Heat Treatment  | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|                       | 675°C- 705°C 1h | 560                     | 640                  | 20                 | RT                      | HRc      |
|                       |                 |                         |                      |                    | 100                     |          |

|          |              |
|----------|--------------|
| REDRYING | Not required |
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GAS ACC. EN ISO 14175