



CEWELD E 8013-B2

TYPE	Cr and Mo-alloyed rutile low hydrogen coated electrode. (Type CrMo)1		
ANWENDUNGEN	Steam plants, vessel, waste plants, cementation steels, boiler works, tubes, heat exchangers		
EIGENSCHAFTEN	Rutile stick electrode for welding of steam production plants, steam pipes and similar joints made of Cr-Mo alloyed steel. The weld metal is resistant to working temperatures up to 550°C. as for similarly alloyed steels, quenched and tempered for cementation and nitrating.		
KLASSIFIKATION	AWS	A 5.5: E 8013-G	
	EN ISO	3580-A: E CrMo1 R 12	
	F-nr	4	
	FM	3	

GEEIGNET FÜR	Typ 1Cr 0,5Mo, ISO 15608: ~5,1 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357, 1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V 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
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ZULASSUNGEN	CE
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SCHWEISSPOSITIONEN	      
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TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Cr	Mo
	0.1	0.3	0.6	0.02	0.02	1.1	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
					RT	
	675°C- 705°C 2h	500	600	22	60	HRc

RÜCKTROCKNUNG	400°C / 1 hr
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GAS ACC. EN ISO 14175