

CEWELD SACW CrMo2

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.

PROPRIÉTÉS 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

CONVIENT POUR

2,25% Cr, 1% Mo
 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
 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,

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



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	S	Cr	Mo
	0.09	0.25	0.9	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	
	675°C- 705°C 1h	560	640	20	100	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175