



# CEWELD E CrMo5

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                         |           |                         |     |          |
|--------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------|-------------------------|-----|----------|
| TYPE                                                   | Medium and high alloyed basic electrodes for welding creep resistant steels                                                                                                                                                                                                                                                                                                                                                                                       |                            |                         |           |                         |     |          |
| APPLICATIONS                                           | Construction and maintenance of power stations, oil (crack plant) and chemical plants                                                                                                                                                                                                                                                                                                                                                                             |                            |                         |           |                         |     |          |
| PROPRIÉTÉS                                             | Cr and Mo-alloyed basic elektrode for welding creep resistant steels and steel casting for working temperatures up to 600°C. The weld metal is resistant to high hydrogen pressure.                                                                                                                                                                                                                                                                               |                            |                         |           |                         |     |          |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                               | A 5.5: E 8015-B6           |                         |           |                         |     |          |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 3580-A: E CrMo5 B 42 H5    |                         |           |                         |     |          |
|                                                        | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 1.7373                     |                         |           |                         |     |          |
|                                                        | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 4                          |                         |           |                         |     |          |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 4                          |                         |           |                         |     |          |
| CONVIENT POUR                                          | <b>5%Cr-0.5% Mo ISO 15608: ~5,3 (C&lt;0,35, 3,5 % &lt; Cr ≤ 7,0 % and 0,4 % &lt; Mo ≤ 0,7 %)</b><br>1.7259, 1.7273, 1.7276, 1.7281, 1.7362, 1.7363, 1.7365, 1.7366, 1.7375, 1.7379, 1.7380, 1.8075<br>GX12CrMo5, X12CrMo5, 10CrMo9-10, 12CrMo9-10, 26CrMo7, 24CrMo10, 10CrMo11, 16CrMo9-3, 10CrSiMoV7<br>ASTM A 182 Gr. F5; A 193 Gr. B5; A 213 Gr. T5; A217 Gr. C5; A 234 Gr. WP5; A 314 Gr. 501; A335 Gr. P5 u. P5c; A 369 Gr. FB 5; A 387 Gr. 5; A 426 Gr. CP5 |                            |                         |           |                         |     |          |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                            |                         |           |                         |     |          |
| POSITIONS DE SOUDAGE                                   | <div>PAPBPCPEPF</div>                   |                            |                         |           |                         |     |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Si                         | Mn                      | Cr        | Ni                      | Mo  |          |
|                                                        | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 0.4                        | 0.7                     | 5         | 0.05                    | 0.5 |          |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat<br>Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                 | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |     | Hardness |
|                                                        | 725°C- 755°C 2h                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 520                        | 630                     | 22        | RT                      | 0°C |          |
|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                         |           | 100                     | 60  | HRc      |
| ETUVAGE                                                | 400°C / 1 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                         |           |                         |     |          |
| GAS ACC. EN ISO 14175                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                         |           |                         |     |          |



# CEWELD E CrMo5

E CRM05 2,5 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,6     | 8720663400581 |

E CRM05 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,5     | 8720663400598 |

E CRM05 4,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3,3     | 8720663400604 |

E CRM05 5,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3,3     | 8720663400611 |