

CATEGORY	GTAW Solid wires	
TYPE	CrMoV6 filler metal for welding similar type of steels. (Air 9117 - 15CDV6)	
APPLICATIONS	CEWELD CrMoV6 Tig finds its application in the aerospace and motorsports industries, and also in the repair of some tool steels. According AIR 9117, LN 9425 an EN 4334.	
PROPERTIES	CEWELD® SG CrMoV6 (EN 4334: FE-WL1806 (15CrMnMoV5-4-9-3) wire is used for welding matching, and similar, composition base materials. The weld deposit from Typ 15CrMoV6 provides high strength, actual strength being dependent on heat treatment Preheat, interpass temperature and PWHT will be dependent on application and base material.	
CLASSIFICATION	DIN	4334 FE-WL1806 (15CrMnMoV5-4-9-3) W.Nr. 1.7734
SUITABLE FOR	15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12, 15CDV6, 1.7734	
APPROVALS	CE	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Mo	V
0.14	0.15	1	0.008	0.008	1.4	0.9	0.22

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2}	R _m	A ₅	Hardness
	MPa	MPa	(%)	Rockwell C
As Welded /	620	680	18	Avg. 42

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS	CURRENT (A) DC-	PACKING (KG)	
			SINGLE	MASTER
1.2 X 1000		30-70	5	25
1.6 X 1000		50-80	5	25
2.0 X 1000		70-110	5	25
2.4 X 1000		110-180	5	25
3.2 X 1000		150-250	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1