CEWELD® S2 CrMo2

CATEGORY	SAW Arc Submerged
TYPE	Submerged Arc wire for welding temperature resistant boiler steels and base metals.
APPLICATIONS	Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petrol-chemical industries.
PROPERTIES	Submerged arc welding wire for high temperature creep resistant 2,45%Cr 1,0%Mo ferritic steel. These steels are used for creep resisting applications up to ~550°C. The wire has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor (X< 10 ppm) for temper embrittlement resistant applications. Recommended flux: FL 155

CLASSIFICATION

AWS	A 5.23: EB3~
EN ISO	24598-A: S CrMo2
F-nr	6
FM	3

SUITABLE FOR	ASTM: A182 Grade F22, A199/A200 Grades T21/T22, A213 grade T22, A217 Grade WC9, A234 Grade WP22, A335 Grade P22, A387 Grades 21/22 10CrMo 9-10, 10CrSiMoV 7, G-17CrMo 9-10
APPROVALS	CE

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.1	0.25	0.95	0.01	0.01	2.45	1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -20°C
690°C±15°C /3h	500	600	24	100	50

WELDING PARAMETERS / PACKING

WELDING PARAMETERS D (MM)	WELDING PARAMETERS VOLTAGE (V)	WELDING PARAMETERS CURRENT (A)	PACKING SPOOL TYPE	PACKING KG / SPOOLS / DRUMS	PACKING KG / PALLET
1.6	27-30	150-300	K-415 / DRUM	25-27 / 350	
2.0	28-34	180-320	K-415 / DRUM	25-27 / 350	
2.4	28-38	250-500	K-415 / DRUM	25-27 / 350	
3.0	28-40	400-800	K-415 / DRUM	25-27 / 350	
4.0	28-40	500-900	K-415 / DRUM	25-27 / 350	

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	