

CATEGORY SAW Arc Submerged

TYPE Seamless copper coated wire Type11

APPLICATIONS These steels are used for creep resisting applications up to -550 °C.

PROPERTIES SACW CrMo1 is a cored wire for high temperature creep resistant 1.25%Cr-0.5%Mo ferritic steel, i.e. P11/P12 Typical with FL 155 Flux or FL 160

CLASSIFICATION

AWS	A 5.23: EB2
EN ISO	24598-A: S T CrMo1
F-nr	6
FM	4

SUITABLE FOR **Type 1Cr 0,5Mo, ISO 15608: ~ 5.1**
 1.7335, 1.7262, 1.7728, 1.7218, 1.7225, 1.7258, 1.7354, 1.7357,
 13CrMo4-5, 15CrMo5, 16CrMoV4, 25CrMo4, 42CrMo4, 24CrMo5, G22CrMo5-4, G17CrMo5-5
 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

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.1	0.2	0.8	0.015	0.015	1.2	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V
675°C- 705°C /1h	470	570	22	100	-20°C 50

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175