



Solid filler metal

Ceweld[®] SG-CrMo-1

Type: Copper coated welding wire for welding creep and hydrogen –resistant steels for working temperatures up to 550° Celsius.

Applications: High pressure boiler steels, offshore, repair, construction, pipelines etc...

Heat resistant steels: 13CrMo4 5 (1.7335), 15CrMo5, 16CrMoV4, 22Mo4, G22CrMo5 4 (1.7354), G17CrMo5 5 (1.7357), A193 Grade B7, A335 Grade P11, A335 Grade P12

Other steels: 42CrMo4 (Rm < 780 Mpa)

Properties: Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi–automatic applications. Weldable with Co2 and Mix gas.

Standards:

AWS A.5.28	:	ER 80 S-G	
EN 12070	:	G CrMo 1 Si	
DIN 8575	:	SG CrMo 1	W.Nr.: 1.7339

Welding positions : according EN 287: PA, PB, PC, PD, PE, PF, PG

Analyses %

C	Mn	Si	Cr	Mo	Cu
0.09	1.00	0.60	1.15	0.50	<0.25

Mechanical properties :

Heat treatment	Shield gas EN 439	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact strenght ISO-V-J	
					+20 °C	- 40 °C
SR	M21	>450	>560	>22	>80	-

(For 13CrMo 4 5 preheating at 200-250°C, PWHT 660-700°C >0,5 Hr with slow cooling down)

Sizes: Mag 0,8 mm, 1,0 mm, 1,2 mm
Tig 1,6 mm, 2,0 mm, 2,4 mm, 3,2 mm x 1000 mm

Package: Mag: K-300, D-300, Drum, B3
Tig: 5 and 25 kg cartons

Mag: Current DC +
Tig : Current DC-

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to chose its suitability for his intended application.