

## SACW CrMo-2

**CATEGORY** SAW Arc Submerged

**TYPE** High- basicity flux-cored wire for submerged-arc welding.

**APPLICATIONS** Construction of containers, Boiler and machinery parts, Steam boilers and turbines, 2,25Cr1Mo steels, pipelines. Suitable for one- of multi layer welding.

**PROPERTIES** Absolutely crack resistant weld metal conditioned by the high-basic slag in combination with very low hydrogen content. Suitable for heat treatment. Step cooling is possible. High reserve of toughness and crack resistance.

**CLASSIFICATION** AWS A 5.23: F9P2-ECB3-B3  
EN ISO 24598: S T CrMo2 FB

**SUITABLE FOR** Boiler steels 10CrMo9-10, 10CrSiMoV7, 12CrMo9-10, A 387, CrMo2

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT ANALYSIS WITH FL155 (WEIGHT %)**

C	Mn	Si	Cr	Ni	Mo	P	S
0.09	1.1	0.3	2.3	-	1.1	<0.015	<0.015

**MECHANICAL PROPERTIES WITH FL155**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness HRc / HV
				RT	0°C -20°C	
SR	>540	620-760	21		180	

SR stress relief annealed 675-705°C / 60 min.

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / drum	kg / pallet
2,0	28-34	180-320	K-415 / Drum	25 / 300	1000
2,4	28-38	250-500	K-415 / Drum	25 / 300	1000
3,2	28-40	400-800	K-415 / Drum	25 / 300	1000
4,0	28-40	500-900	K-415 / Drum	25 / 300	1000

**REDRYING TEMPERATURE** Not required