

# CEWELD SG CrMoV6

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                         |                                   |    |                            |                         |           |          |      |      |
|--------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|----|----------------------------|-------------------------|-----------|----------|------|------|
| TYPE                                                   | Solid wire CrMoV6 for welding similar type of steels. (Air 9117 - 15CDV6)                                                                                                                                                                                                                                                                                                                               |                                   |    |                            |                         |           |          |      |      |
| APPLICATIONS                                           | CEWELD® SG CrMoV6 is applicable for use in the aerospace and motorsports industries and also in the repair of some tool steels. According AIR 9117, LN 9425 an EN 4334.                                                                                                                                                                                                                                 |                                   |    |                            |                         |           |          |      |      |
| PROPRIÉTÉS                                             | CEWELD® SG CrMoV6 (EN 4334: FE-WL1806 (15CrMnMoV5-4-9-3) wire is used for welding matching, and similar, composition base materials. <b>The weld deposit from Typ 15CrMoV6 provides high strength. Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.</b> |                                   |    |                            |                         |           |          |      |      |
| CLASSIFICATION                                         | DIN                                                                                                                                                                                                                                                                                                                                                                                                     | 4334 FE-WL1806 (15CrMnMoV5-4-9-3) |    |                            |                         |           |          |      |      |
|                                                        | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                   | 1.7734                            |    |                            |                         |           |          |      |      |
| CONVIENT POUR                                          | 1.7734<br>15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12, 15CDV6,                                                                                                                                                                                                                                                                                                                                                 |                                   |    |                            |                         |           |          |      |      |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                                                                                                      |                                   |    |                            |                         |           |          |      |      |
| POSITIONS DE SOUDAGE                                   | <div>PA</div> <div>PB</div> <div>PC</div> <div>PF</div>             |                                   |    |                            |                         |           |          |      |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                       | Si                                | Mn | P                          | S                       | Cr        | Mo       | V    | Fe   |
|                                                        | 0.14                                                                                                                                                                                                                                                                                                                                                                                                    | 0.15                              | 1  | 0.008                      | 0.008                   | 1.4       | 0.9      | 0.22 | Rem. |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                          |                                   |    | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |      |      |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                                                                                                               |                                   |    | 850                        | 1100                    | 10        | HRc      |      |      |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                                                            |                                   |    |                            |                         |           |          |      |      |
| GAS ACC. EN ISO 14175                                  | M21                                                                                                                                                                                                                                                                                                                                                                                                     |                                   |    |                            |                         |           |          |      |      |

# CEWELD SG CrMoV6

SG CRM0V6 1,2 MMMM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720682051696 |