

SG Mo Tig

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid copper coated Tig welding wire for 0,5% Mo steels.
APPLICATIONS	Creep resistant steels, steam tubing, vessel, boilers, apparatus etc..
PROPERTIES	Excellent welding properties and mechanical strength upto 460 N/mm ² yield strength. Excellent to be used for creep resisting service at temperatures up to 500°C.

CLASSIFICATION	AWS	A 5.28: ER 70S-A1
	EN ISO	636-A: W 46 4 2Mo 21952-A: W MoSi FM1 / FM 3
	DIN: W.Nr.	1.5424

SUITABLE FOR	Creep resistant steels: 15mo3, 16Mo3, 17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1 Boiler steels: P235GH, P310GH Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70 Fine-grain steels: S255N, S460N, P255NH, P460NH, P460NL1 Cast steels: GE 240, GE 300
--------------	---

APPROVALS	CE approved
-----------	-------------

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo
0.09	1.20	0.60	< 0.15	< 0.15	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
AW	> 480	> 580	> 22	180	> 47
PWHT	> 400	> 510	> 19	200	

AW: as welded / PWHT: 620°C / 1 Hr

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current (A) (DC-)	(single)	(master)
1.6 x 1000 mm	50-90	5 kg cartons	25 kg cartons
2.0 x 1000 mm	70-110	5 kg cartons	25 kg cartons
2.4 x 1000 mm	110-180	5 kg cartons	25 kg cartons
3.2 x 1000 mm	180-320	5 kg cartons	25 kg cartons

REDRYING TEMPERATURE	not required
----------------------	--------------

GAS ACC. EN ISO 14175:	I1-3
------------------------	------