

## SG Mo Tig

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

<b>CLASSIFICATION</b>	AWS	A 5.28: ER 80 S-G
	EN ISO	21952-A: W Mo Si
	DIN: W.Nr.	1.5424
	DIN	8575: SG Mo

<b>SUITABLE FOR</b>	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
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<b>APPROVALS</b>	CE approved
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### 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 <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	
				-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

D (mm)	Welding Parameters		Packing	
	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
3.0 x 1000 mm	180-320		5 kg cartons	25 kg cartons

<b>REDRYING TEMPERATURE</b>	not required
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<b>GAS ACC. EN ISO 14175:</b>	I1-3
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