

S2 Mo

CATEGORY	SAW Submerged arc		
TYPE	Solid wire for submerged arc welding with 0,5% Mo		
APPLICATIONS	Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).		
CLASSIFICATION	AWS	A 5.23: EA 2	
	EN ISO	14171-A: S2Mo	
	DIN: W.Nr.	1.5425	
	DIN	8575: S2Mo	

SUITABLE FOR

Materials	DIN	EN	ASTM
Boiler steels	HI, HII, 17Mn4, 19Mn5,	P235GH, P355GH,	Typical
-	15Mo3, 16Mo3	16Mo3	A 285Gr C
Pipe steels	St35.8, St45.8, StE 210.7TM	P235T1/T2, P460NL2	A 515Gr 70
-	StE 445.7 TM	L210, L445MB	A 516Gr 70
Fine grain steels	StE 255 - StE 460	S255 - S460QL1	-
-	17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1, Boiler steels: P235GH, P310GH, ASTM A516 grade 60, Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70 Fine-grain steels:, S460N, P255NH, P460NH, P460NL1, Cast steels: GE 240, GE 300		

APPROVALS	TUV (12523.00), CE approved
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WELDING POSITIONS:



C	Mn	Si	S	P	Cr (Other)	Ni (Other)	Mo	Cu *	V	Others
0.05-0.17	0.95-1.35	0.20	0.025	0.025	0.005-0.030	0.005-0.030	0.45-0.65	0.35	-	0.005-0.030

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>460	530-680	>20	>60	>47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters				Packing	
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum	kg / pallet
2,0			K-415 / Drum	25 / 300	
2.4			K-415 / Drum	25 / 300	
3.2			K-415 / Drum	25 / 300	
4.0			K-415 / Drum	25 / 300	

REDRYING TEMPERATURE	not required
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