

CATEGORY	Oxi-Acetylene welding	
TYPE	High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.	
APPLICATIONS	Finegrain and creep resistant molybdenum containing steels. Suitable for working temperatures up to 500°Celsius. It's suited in trade and industry for welding plates, pipes, boilers and other profiles.	
PROPERTIES	High strength Manganese-Molybdenum- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding. Excelent mechanical strenght due to the addition of Molybdenium.The deposit is homogenous and suitable for heat treatment (PWHT).	
CLASSIFICATION	AWS EN ISO F-nr FM	A 5.2: R60-G 20378: 0 IV 6 1

SUITABLE FOR St37, St42, St35.8, St45.8, 15Mo3, HI, HIII, HII, 17Mn4, 1.0038, 1.0570, 1.0305, 1.0405, 1.5415, 1.0345, 1.0435, 1.0481, 15Mo3, 16Mo3

APPROVALS CE



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Mo
0.12	0.2	1.1	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
As Welded /	350	500	22	60

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS		WELDING PARAMETERS	PACKING
	WELDING PARAMETERS	LENGTH (MM)		
2.0		914 / 1000		KG / TUBE / CARTON 5 / 25
2.4		914 / 1000		5 / 25
3.2		914 / 1000		5 / 25
4.0		914 / 1000		5 / 25
5.0		914 / 1000		5 / 25

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 None