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| CATEGORY | SAW Arc Submerged | |
| TYPE | Seamless copper coated wire Type P1 | |
| APPLICATIONS | SA CW Mo is a cored wire for 0.5%Mo steels, i.e. P1. These steels are commonly used at service temperatures up to 500 °C and for some sub-zero structural applications. | |
| PROPERTIES | The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction. Typical with FL 155 Flux or FL 160 | |
| CLASSIFICATION | AWS EN ISO F-nr FM | A 5.23: F8A4-ECA1 24598-A: S T Mo FB 6 4 |
| SUITABLE FOR | S355J0, E335, P285NH, P310GH, S355J0Cu, 16Mo3, P315N - S420N, P315NH - P420NH fine grain structural steels up to S460N/P460N, large-diameter pipes up to L485MB | |
| APPROVALS | No Approvals Found | |

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Mo |
|-----|-----|------|------|------|-----|
| 0.1 | 0.2 | 0.09 | 0.02 | 0.02 | 0.5 |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R _{p0.2} MPa | R _m MPa | A ₅ (%) | Impact Energy (J) ISO-V | |
|------------------|--------------------------|-----------------------|-----------------------|-------------------------|-------|
| | | | | -20°C | -40°C |
| 675°C- 705°C /1h | 490 | 570 | 24 | 120 | 80 |

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175