



CEWELD SG Mo Tig

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|----------------|---|-------------------|
| TYPE | Solid copper coated TIG welding wire for 0,5% Mo steels. | |
| ANWENDUNGEN | Creep resistant steels, steam tubing, vessel, boilers, apparatus etc.. | |
| EIGENSCHAFTEN | Excellent welding properties and mechanical strength up to 460 MPa yield strength. Excellent to be used for creep resisting service at temperatures up to 500 °C. | |
| KLASSIFIKATION | AWS | A 5.28: ER 70S-A1 |
| | EN ISO | 636-A: W 46 4 2Mo |
| | W.Nr. | 1.5424 |
| | F-nr | 6 |
| | FM | 1 |

GEEIGNET FÜR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**
 1.5415, 1.0481, 1.0482
15Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;
 API 5 L B, X42, X52, X60, X65

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C | Si | Mn | Mo |
|---|------|-----|-----|-----|
| | 0.09 | 0.6 | 1.2 | 0.5 |

| MECHANISCHE GÜTEWERTE | Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| | | | | | -20°C | -40°C | |
| | As Welded | 480 | 580 | 22 | 180 | 55 | HRc |
| | 620°C±15°C 1h | 400 | 510 | 25 | 200 | HRc | |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 11



CEWELD SG Mo Tig

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|------------------------|-----------|---------|---------------|
| SG MO TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411341 |
| SG MO TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411358 |
| SG MO TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411365 |
| SG MO TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411372 |
| SG MO TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663411389 |