



CEWELD SG Mo

TYPE Solid copper coated welding wire for 0,5% Mo steels.

APPLICATIONS Creep resistant steels, steam tubing, vessel, boilers, apparatus etc..

PROPERTIES Excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. (Mag wire) Excellent to be used for creep resisting service at temperatures up to 500°C.

CLASSIFICATION

AWS	A 5.28: ER 70S-A1
EN ISO	14341-A: G 42 2 C1 2Mo
W.Nr.	1.5424
F-nr	6
FM	2

SUITABLE FOR **Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3**
 1.0481, 1.0482, 1.5415, 1.6368,
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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Mo
0.09	0.6	1.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	490	590	23	100	55	HRc
620°C±15°C 1h	440	510	25	150	HRc	

REDRYING Not required

GAS ACC. EN ISO 14175 M21, C1



CEWELD SG M₀

SG M₀ 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405609
D-100	1	8720663405586
D-200	5	8720663405593

SG M₀ 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405616
D-200	5	8720663405623

SG M₀ 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405630
Drum	250	8720663405647

SG M₀ 1,6MM

Packaging	KG/unit	EanCode
Drum	250	8720663405715