

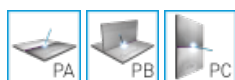


CEWELD SACW Mo

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.								
PROPRIÉTÉS	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.23: F8A4-ECA1</td> </tr> <tr> <td>EN ISO</td> <td>24598-A: S T Mo FB</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>4</td> </tr> </table>	AWS	A 5.23: F8A4-ECA1	EN ISO	24598-A: S T Mo FB	F-nr	6	FM	4
AWS	A 5.23: F8A4-ECA1								
EN ISO	24598-A: S T Mo FB								
F-nr	6								
FM	4								
CONVIENT POUR	S355J0, E335, P285NH, P310GH, S355J0Cu, 16Mo3, P315N - S420N, P315NH - P420NH fine grain structural steels up to S460N/P460N, large-diameter pipes up to L485MB								

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
675°C- 705°C 1h	490	570	24	120	80	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175