



CEWELD SG Mo Laser welding wire

TYPE	Welding wire for changing and repairing shaped cavities in hardened materials				
APPLICATIONS	Laser welding				
PROPERTIES	The weld can be eroded, structured, polished, chrome-plated, etched, nitrated, annealed and hardened.				
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.28: ER 80S-G 21952-A: G MoSi 1.5424			
SUITABLE FOR	Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 1.5415, 1.0481, 1.0482 15 Mo3, 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	No Approvals Found				
WELDING POSITIONS	 PA  PB  PC				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C 0.1	Si 0.6	Mn 1.1	P 0.015	S 0.015 Mo 0.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /1h	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Rockwell C Avg. 33
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175					