



# CEWELD SG Mo Tig

**TYPE** TIG welding wire for 15Mo3 and similar 0,5% Mo steels.

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

**PROPERTIES** 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.

**CLASSIFICATION**

AWS	A 5.28: ER 70S-A1
EN ISO	636-A: W 46 4 2Mo
EN ISO	21952-A: W MoSi
F-nr	6
FM	1
FM	3
W.Nr.	1.5424

**SUITABLE FOR** **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

**APPROVALS** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Mo
0.09	0.6	1.2	0.5

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
As Welded /	480	580	22	180	55
620°C±15°C /1h	400	510	25	200	

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** 11



# CEWELD SG Mo Tig

SG MO TIG 1,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411341
SG MO TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411358
SG MO TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411365
SG MO TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411372
SG MO TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663411389