



# CEWELD S2 Mo

|                       |   |               |  |
|-----------------------|---|---------------|--|
| <b>TYPE</b>           | Solid wire for submerged arc welding with 0,5% Mo   |               |  |
| <b>APPLICATIONS</b>   | Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70). |               |  |
| <b>PROPERTIES</b>     | Copper coated SAW wire best in combination with flux FL 155   |               |  |
| <b>CLASSIFICATION</b> | AWS   | A 5.23: EA2   |  |
|                       | EN ISO  | 14171-A: S2Mo |  |
|                       | EN ISO  | 24598-A: S Mo |  |
|                       | F-nr  | 6             |  |
|                       | FM  | 3             |  |
|                       | W.Nr.   | 1.5425        |  |

**SUITABLE FOR**

| Materials         | DIN                         | EN                 | ASTM       |
|-------------------|-----------------------------|--------------------|------------|
| Boiler steels     | HI, HII, 17Mn4, 19Mn5,      | P235GH, P355GH,    | Typical    |
| -                 | 15Mo3, 16Mo3                | 16Mo3              | A 285Gr C  |
| Pipe steels       | St35.8, St45.8, StE 210.7TM | P235T1/T2, P460NL2 | A 515Gr 70 |
| -                 | StE 445.7 TM                | L210, L445MB       | A 516Gr 70 |
| Fine grain steels | StE 255 - StE 460           | S255 - S460QL1     | -          |

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17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1, Boiler steels: P235GH, P310GH, ASTM A516 grade 60, Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70 Fine-grain steels:, S460N, P255NH, P460NH, P460NL1, Cast steels: GE 240, GE 300

**APPROVALS** TÜV (12523) CE

**WELDING POSITIONS**



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

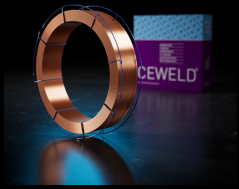
| C   | Si   | Mn  | P     | S     | Mo  |
|-----|------|-----|-------|-------|-----|
| 0.1 | 0.15 | 1.1 | 0.015 | 0.015 | 0.5 |

**ALL WELD MECHANICAL PROPERTIES**

| Heat Treatment                | R <sub>p0,2</sub><br>MPa | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |          |          |
|-------------------------------|--------------------------|-----------------------|-----------------------|-------------------------|----------|----------|
|                               |                          |                       |                       | RT                      | -20°C    | -40°C    |
| As Welded /<br>580°C±15°C /2h | 520<br>500               | 600<br>610            | 25<br>25              | 100                     | 90<br>60 | 50<br>50 |

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175**



# CEWELD S2 Mo

## S2 MO 2,0MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| Drum  | 300     | 8720663404633 |
| K-415 | 25      | 8720663404695 |

## S2 MO 2,4MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| Drum  | 300     | 8720663404626 |
| K-415 | 27      | 8720663424211 |

## S2 MO 3,2MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| K-415 | 27      | 8720663404664 |

## S2 MO 4,0MM

| Type  | KG/unit | EANCode       |
|-------|---------|---------------|
| Drum  | 370     | 8720663404640 |
| K-415 | 25      | 8720663404688 |