

CEWELD SG Mo

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|----------------|---|-------------------------|
| 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 |
| | AWS | A 5.28: ER 80S-G |
| | EN ISO | 14341-A: G 42 2 C1 2Mo |
| | EN ISO | 14341-A: G 46 6 M21 2Mo |
| | EN ISO | 21952-A: G MoSi |
| | F-nr | 6 |
| | FM | 2 |
| | W.Nr. | 1.5424 |

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| SUITABLE FOR | <p>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</p> |
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APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

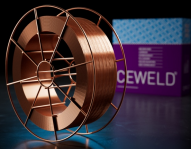
| C | Si | Mn | Mo |
|------|-----|-----|-----|
| 0.09 | 0.6 | 1.2 | 0.5 |

ALL WELD MECHANICAL PROPERTIES

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

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21, C1



CEWELD SG M₀

SG M₀ 0,8MM

| Type | KG/unit | EANCode |
|--------|---------|---------------|
| BS-300 | 15 | 8720663405609 |
| D-100 | 1 | 8720663405586 |
| D-200 | 5 | 8720663405593 |

SG M₀ 1,0MM

| Type | KG/unit | EANCode |
|--------|---------|---------------|
| BS-300 | 15 | 8720663405616 |
| D-200 | 5 | 8720663405623 |

SG M₀ 1,2MM

| Type | KG/unit | EANCode |
|--------|---------|---------------|
| BS-300 | 15 | 8720663405630 |
| Drum | 250 | 8720663405647 |

SG M₀ 1,6MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Drum | 250 | 8720663405715 |