CEWELD SG Mo

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid copper coated welding wire for 0,5% Mo steels.(G 2Mo, ER 70S-A1)
APPLICATIONS	CEWELD® SG Mo is for gas-shielded arc welding, both with mixed gas and with CO2, of high-temperature low-alloy steels. Fields of application are. Boiler, tank, pipeline, equipment and reactor construction.
PROPERTIES	CEWELD® SG Mo has excellent welding properties and is ideal for heat-resistant applications up to 500°C.

CLASSIFICATION

AWS	A 5.28: ER 70S-A1, A 5.28: ER 80S-G
EN ISO	14341-A: G 42 2 C1 2Mo, 14341-A: G 46 6 M21 2Mo, 21952-A: G MoSi
W.Nr.	1.5424
F-nr	6
FM	1

SUITABLE FOR

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

APPROVALS: CE, DB: 42.206.05

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Mo
0.09	0.6	1.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	490	590	23	100	55	HRc
620°C±15°C 1h	440	510	25	150	HRc	

REDRYING: Not required

GAS ACC. EN ISO 14175: M21, C1

CEWELD SG Mo

SG MO 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405609
D-100	1	8720663405586
D-200	5	8720663405593

SG MO 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405616
D-200	5	8720663405623

SG MO 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405630
Drum	250	8720663405647

SG MO 1,6MM

Packaging	KG/unit	EanCode
Drum	250	8720663405715