



# CEWELD SACW Mo

**TYPE** Seamless copper coated wire Type P1

**APPLICATIONS** SA CW Mo is a cored wire for 0.5%Mo steels, i.e. P1. These steels are commonly used at service temperatures up to 500 °C and for some sub-zero structural applications.

**PROPERTIES** The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction. Typical with FL 155 Flux or FL 160

**CLASSIFICATION**

|        |                    |
|--------|--------------------|
| AWS    | A 5.23: F8A4-ECA1  |
| EN ISO | 24598-A: S T Mo FB |
| F-nr   | 6                  |
| FM     | 4                  |

**SUITABLE FOR** S355J0, E335, P285NH, P310GH, S355J0Cu, 16Mo3, P315N - S420N, P315NH - P420NH fine grain structural steels up to S460N/P460N, large-diameter pipes up to L485MB

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si  | Mn   | P    | S    | Mo  |
|-----|-----|------|------|------|-----|
| 0.1 | 0.2 | 0.09 | 0.02 | 0.02 | 0.5 |

**MECHANICAL PROPERTIES**

| Heat Treatment  | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
|                 |                         |                      |                    | -20°C                   | -40°C |          |
| 675°C- 705°C 1h | 490                     | 570                  | 24                 | 120                     | 80    | HRc      |

**REDRYING** Not required

**GAS ACC.** EN ISO 14175