



# CEWELD SG Mo

| TYPE                                                 | Fil de soudure cuivré pour les aciers 0,5% Mo.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|-------|-----------|-----|-----|----|-----|----|-----|---------------|-----|-----|----|-----|-----|--|
| APPLICATIONS                                         | Aciers résistant au fluage, tubes à vapeur, cuves, chaudières, appareils, etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| PROPRIÉTÉS                                           | Excellentes propriétés de soudage. Qualité élevée reconnue dans le monde entier, avec une coulée et une hélice contrôlées pour les applications semi-automatiques ou semi-automatiques. (Fil Mag)<br>Excellent pour le service de résistance au fluage à des températures allant jusqu'à 500°C.                                                                                                                                                                                                                                                                                                                                                                                 |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| CLASSIFICATION                                       | AWS A 5.28: ER 70S-A1, A 5.28: ER 80S-G<br>EN ISO 14341-A: G 42 2 C1 2Mo, 14341-A: G 46 6 M21 2Mo, 21952-A: G MoSi<br>W.Nr. 1.5424<br>F-nr 6<br>FM 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| CONVIENT POUR                                        | <b>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3</b><br>1.0481, 1.0482, 1.5415, 1.6368,<br><b>15Mo3, 16Mo3</b> , 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<br>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;<br>API 5 L B, X42, X52, X60, X65 |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| AGRÉMENTS                                            | CE, DB: 42.206.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| POSITIONS DE SOUDAGE                                 | <div></div>                                                                |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | <table><tr><td>C</td><td>Si</td><td>Mn</td><td>Mo</td></tr><tr><td>0.09</td><td>0.6</td><td>1.2</td><td>0.5</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | C              | Si                      | Mn                   | Mo                 | 0.09                    | 0.6                | 1.2      | 0.5                     |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| C                                                    | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Mn             | Mo                      |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| 0.09                                                 | 0.6                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 1.2            | 0.5                     |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| PROPRIÉTÉS MÉCANIQUES                                | <table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R<sub>P0,2</sub> (MPa)</th><th rowspan="2">R<sub>m</sub> (MPa)</th><th rowspan="2">A<sub>5</sub> (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-20°C</th><th>-40°C</th></tr><tr><td>As Welded</td><td>490</td><td>590</td><td>23</td><td>100</td><td>55</td><td>HRc</td></tr><tr><td>620°C±15°C 1h</td><td>440</td><td>510</td><td>25</td><td>150</td><td>HRc</td><td></td></tr></table>                                                                                                                                                                          | 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 | As Welded | 490 | 590 | 23 | 100 | 55 | HRc | 620°C±15°C 1h | 440 | 510 | 25 | 150 | HRc |  |
| 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                   |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| As Welded                                            | 490                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 590            | 23                      | 100                  | 55                 | HRc                     |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| 620°C±15°C 1h                                        | 440                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 510            | 25                      | 150                  | HRc                |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| ETUVAGE                                              | Non requis                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| GAS ACC. EN ISO 14175                                | M21, C1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                |                         |                      |                    |                         |                    |          |                         |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |



# CEWELD SG M0

## SG M0 0,8MM

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

## SG M0 1,0MM

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

## SG M0 1,2MM

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

## SG M0 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 250     | 8720663405715 |