

## G4 (H44Mo)

<b>CATEGORY</b>	Oxi-Acetylene welding
<b>TYPE</b>	High strength Mn / Mo- alloyed filler metal for flame and Tig welding with extreme good flowing properties without spatters during welding.
<b>APPLICATIONS</b>	Finegrain and creep resistant molybdenum containing steels. Suitable for working temperatures up to 500°Celsius. It's suited in trade and industry for welding plates, pipes, boilers and other profiles.
<b>PROPERTIES</b>	High strength Manganese-Molybdenum- alloyed filler metal for flame welding with extreme good flowing properties without spatters during welding. Excelent mechanical strenght due to the addition of Molybdenium. The deposit is homogenous and suitable for heat treatment (PWHT).

<b>CLASSIFICATION</b>	AWS	A 5.2: R 65
	EN ISO	12536: O IV
	DIN: W.Nr.	1.5425
	DIN	8554: G IV

<b>SUITABLE FOR</b>	St37, St42, St35.8, St45.8, 15Mo3, HI, HIII, HII, 17Mn4, 1.0038, 1.0570, 1.0305, 1.0405, 1.5415, 1.0345, 1.0435, 1.0481, 15Mo3, 16Mo3
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<b>APPROVALS</b>	CE approved
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**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Mo
0.11	1.0	0.20	0.50

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V +20°C
AW	> 350	450-550	> 22	> 60

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing
	Length (mm)		kg / tube / carton
2.0	914 / 1000		5 / 25
2.4	914 / 1000		5 / 25
3.2	914 / 1000		5 / 25
4.0	914 / 1000		5 / 25
5.0	914 / 1000		5 / 25

<b>REDRYING TEMPERATURE</b>	not required
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