

## SG Mo

**CATEGORY** GMAW-GTAW Solid wires

**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 80 S-G
EN ISO	21952-A: G MoSi
DIN: W.Nr.	1.5425
DIN	8575: SG Mo

**SUITABLE FOR**

Creep resistant steels: 15mo3, 16Mo3, 17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1  
 Boiler steels: P235GH, P265GH, P295GH, P310GH  
 Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70  
 Fine-grain steels: S255N, S460N, P255NH, P460NH, P460NL1  
 Cast steels: GE 240, GE 300  
 W.Nr: 1.5415, 1.5425, 1.0481, 1.0482, 1.0425, 1.0354

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELT METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	Mo
0.09	1.20	0.60	< 0.15	< 0.15	0.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
				-20°C	-40°C
AW	> 480	> 580	> 22	180	> 47
PWHT	> 400	> 510	> 19	200	

AW: as welded / PWHT: 620°C / 1 Hr

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg spool / drum	kg / pallet
0,8	15-24	60-200	D-200 / KD-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,0	16-32	80-300	D-200 / KD-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000
1,2	18-34	120-380	D-200 / KD-300 / Drum	5 / 15 / 250	1000 / 1080 / 1000

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M21