

## RUTWELD Mo

Electrodes MMA [SMAW]

Creep resistant steels

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 3580-A : E 46 Mo R 12 DIN 8575 : E MoR22 AWS A-5.5 : E 7013-G	UDT	Power generation industry Constructions & Engineering Metallurgy (Steelworks)

- Rutile electrode, with the addition of Mo.
- For welding creep resistant steels up to 500°C.
- For joining ferritic heat-resistant, low-alloy steels.

### Application

Recommended for making penetrations and short connection welds.  
For remelting in situations where TIG technology cannot be used.  
Welding of thin elements.

### Base material



DIN	W.Nr.	ISO
St 37 to St 52	1.0037 to 1.0570	
17Mn4	1.0426	P295GH
19Mn6	1.0473	P355GH, PH29
15Mo3	1.5415	16Mo3, F26
St 35.8	1.0345	P235GH
St45-8	1.0425	P265GH, F9
St52-3	1.0570	S355D P355GH, PH29
St45.8	1.0405	P255G1TH L320 do L355NB
StE 415.7 TM	1.8973	L320MB do L355MB
16Mo3	1.5415	16Mo3, F26
17Mn4	1.0481	P295GH, PT490
WStE 355	1.0565	P255NH do P355NH
	1.0562	P255 do P355N

### Typical chemical composition %

C	Si	Mn	Mo
0,06	0,30	0,40	0,50

### Typical mechanical properties

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>460
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	530-680
<b>Elongation A5 [%]</b>	>20
<b>Impact energy Kv [J]</b>	>47J (20°C) /
<b>Coating type</b>	rutile

<b>Welding current</b>	
<b>Welding positions</b>	
<b>Redrying</b>	120°C / 1h
<b>Additional description</b>	Pre-heating temperature, inter-pass temperature, post-weld heat treatment according to base material.

#### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	70-95	4,5	13,5	48
3,2	350 /	115-145	4,0	12,0	
4,0	450 /	145-190			
5,0	450 /	200-240			

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