

## MIGWELD Mo

MIG/MAG Wires [GMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14341-A : G 42 2 C1 2Mo/G 46 6 M21 2Mo DIN 8575 : SG Mo AWS A-5.28 : ER 80S-G (ER 70S-A1)	UDT, TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Solid welding wire with 0,5% Mo for MAG welding.
- Recommended for welding the creep resistant steels, working in the temperature up to 500°C.

### Application

Steam boilers, pipelines, fittings, repair of thermal energy devices

### Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH, 16Mo3
Pipelines:	P235-P355N, 16Mo3
Shipbuilding plates:	A, B, D, E, AH32-EH36
Finegrained steels:	S275-S420

### Typical chemical composition %

C	Si	Mn	Mo
0,10	0,60	1,15	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>	≥560
<b>Elongation A5 [%]</b>	>22
<b>Impact energy Kv [J]</b>	>47] (-20°C) /
<b>Heat treatment</b>	Annealing: 720°C/30 min, furnace cooling to 300°C, then in air
<b>Shielding gases acc. to EN ISO 14175</b>	M21 - Ar + 15 - 25% CO <sub>2</sub> /

### Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	80-95	17-19 short arc	15,0
1,0	240-270	24-27 spray arc	15,0
1,2	110-130	18-20 short arc	15,0
1,2	270-320	27-32 spray arc	15,0

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