MIGWELD NiMo1

MIG/MAG Wires [GMAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 16834-A : G 62 6 M21 Mn3Ni1Mo AWS A-5.28 : ER 100S-G		Constructions & Engineering Mining Petrochemical and chemical industry

Сварочная проволока с добавлением Ni и Mo для сварки мелкозернистых сталей с пределом текучести до 550 Н/мм2.

Base material

EN	DIN, AISI	W.Nr.
	N-A-XTRA56, N-A-XTRA63, N-A-XTRA70, T1, T1A, T1B, X60, X65, X70	
P/S420N-S500NL	EStE490	1.8919
P/S420N-S500NL	TStE500	1.8917
S500Q-S620Q (S500QL-S620QL)		
P500Q-P620Q (P500QL-P620QL)		

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	Cu	P	S
0,12	0,40-0,80	1,30-1,90	0,15	0,80-1,30	0,25-0,65	0,03	0,30	0,015	0,018

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0,25

Typical mechanical properties

Yield strength Re [N/mm2]	>620
Tensile strength Rm [N/mm2]	700-890
Elongation A5 [%]	>18
Impact energy Kv [J]	>47J (-60°C) /
Wire/rod type	Lity
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

ø	Ток сварки [A]	Напряжение дуги [B]	Вес пачки [кг]
1,0	80-95	17-19	15,0 - Łuk zwarciowy

1,0	240-270	24-27	15,0 - Łuk natryskowy
1,2	110-130	18-20	15,0 - Łuk zwarciowy
1,2	270-320	27-32	15,0 - Łuk natryskowy

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