CEWELD SG Mo Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

TIG welding Rod for 15Mo3 and similar 0,5% Mo steels.

APPLICATIONS

CEWELD® SG Mo Tig is for Tig welding of high-temperature low-alloy steels. Fields of application are. Boiler, tank, pipeline, equipment and reactor construction.

PROPERTIES

CEWELD® SG Mo Tig has excellent welding properties and is ideal for heat-resistant applications up to 500°C.

CLASSIFICATION

AWS	A 5.28: ER 70S-A1, A 5.28: ER 80S-G
EN ISO	636-A: W 46 4 2Mo, 21952-A: W MoSi
W.Nr.	1.5424
F-nr	6
FM	1

SUITABLE FOR

Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3
1.5415, 1.0481, 1.0482
15Mo3, 16Mo3, 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300
ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;
API 5 L B, X42, X52, X60, X65

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Mo
0.09	0.6	1.2	0.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-40°C	
As Welded	480	580	22	180	55	HRc
620°C±15°C 1h	400	510	25	200	HRc	

REDRYING

Not required

GAS ACC. EN ISO 14175

I1

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SG MO TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411341

SG MO TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411358

SG MO TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411365

SG MO TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411372

SG MO TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663411389