



CEWELD SG Mo Tig

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)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	480	580	22	-20°C	-40°C	
	620°C±15°C 1h	400	510	25	200	HRc	
REDRYING	Not required						
GAS ACC. EN ISO 14175	I1						



CEWELD SG Mo Tig

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