CEWELD S2 Mo

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid wire for submerged arc welding with 0,5% Mo

ANWENDUNGEN

Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70).

EIGENSCHAFTEN

Copper coated SAW wire best in combination with flux FL 155

KLASSIFIKATION

AWS	A 5.23: EA2
EN ISO	14171-A: S2Mo
W.Nr.	1.5425
F-nr	6
FM	3

GEEIGNET FÜR

Materials	DIN	EN	ASTM
Boiler steels	HI, HII, 17Mn4, 19Mn5,	P235GH, P355GH,	Typical
-	15Mo3, 16Mo3	16Mo3	A 285Gr C
Pipe steels	St35.8, St45.8, StE 210.7TM	P235T1/T2, P460NL2	A 515Gr 70
-	StE 445.7 TM	L210, L445MB	A 516Gr 70
Fine grain steels	StE 255 - StE 460	S255 - S460QL1	-

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17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1, Boiler steels: P235GH, P310GH, ASTM A516 grade 60, Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70 Fine-grain steels:, S460N, P255NH, P460NH, P460NL1, Cast steels: GE 240, GE 300

ZULASSUNGEN

TÜV: 12523, CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Mo
0.1	0.15	1.1	0.015	0.015	0.5

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				RT	-20°C	-40°C	
As Welded	520	600	25	100	90	50	HRc
580°C±15°C 2h	500	610	25	60	50	HRc	

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

CEWELD S2 Mo

S2 MO 2,0MM

Packaging	KG/unit	EanCode
Drum	300	8720663404633
K-415	25	8720663404695

S2 MO 2,4MM

Packaging	KG/unit	EanCode
Drum	300	8720663404626
K-415	27	8720663424211

S2 MO 3,2MM

Packaging	KG/unit	EanCode
K-415	27	8720663404664

S2 MO 4,0MM

Packaging	KG/unit	EanCode
Drum	370	8720663404640
K-415	25	8720663404688