



CEWELD SG Mo Tig

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

APPLICATIONS Creep resistant steels, steam tubing, vessel, boilers, apparatus etc..

PROPERTIES Excellent welding properties and mechanical strength up to 460 MPa yield strength. Excellent to be used for creep resisting service at temperatures up to 500 °C.

CLASSIFICATION

AWS	A 5.28: ER 70S-A1
EN ISO	636-A: W 46 4 2Mo
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
				-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



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