



CEWELD S2 Mo

| | | | |
|----------------------|---|---------------|--|
| TYPE | Solid wire for submerged arc welding with 0,5% Mo | | |
| TOEPASSINGEN | Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70). | | |
| EIGENSCHAPPEN | Copper coated SAW wire best in combination with flux FL 155 | | |
| CLASSIFICATIE | AWS | A 5.23: EA2 | |
| | EN ISO | 14171-A: S2Mo | |
| | W.Nr. | 1.5425 | |
| | F-nr | 6 | |
| | FM | 3 | |

GESCHIKT VOOR

| 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

GOEDKEURINGEN TÜV: 12523, CE

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

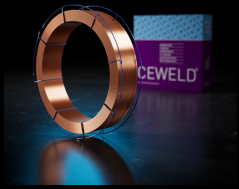
| C | Si | Mn | P | S | Mo |
|-----|------|-----|-------|-------|-----|
| 0.1 | 0.15 | 1.1 | 0.015 | 0.015 | 0.5 |

MECHANISCHE WAARDEN

| Heat Treatment | R _{PO,2} (MPa) | R _m (MPa) | A ₅ (%) | 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 | |

HERDROGEN 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 |