



CEWELD SG Mo

TYPE	Solid copper coated welding wire for 0,5% Mo steels.(G 2Mo, ER 70S-A1)																												
APPLICATIONS	CEWELD® SG Mo is for gas-shielded arc welding, both with mixed gas and with CO2, of high-temperature low-alloy steels. Fields of application are. Boiler, tank, pipeline, equipment and reactor construction.																												
PROPERTIES	CEWELD® SG Mo 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 14341-A: G 42 2 C1 2Mo, 14341-A: G 46 6 M21 2Mo, 21952-A: G MoSi W.Nr. 1.5424 F-nr 6 FM 1																												
SUITABLE FOR	Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3 1.0481, 1.0482, 1.5415, 1.6368, 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, DB: 42.206.05																												
WELDING POSITIONS																													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>Mo</td></tr><tr><td>0.09</td><td>0.6</td><td>1.2</td><td>0.5</td></tr></table>						C	Si	Mn	Mo	0.09	0.6	1.2	0.5															
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MECHANICAL PROPERTIES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{p0,2} (MPa)</th><th rowspan="2">R_m (MPa)</th><th rowspan="2">A5 (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-20°C</th><th>-40°C</th></tr><tr><td>As Welded</td><td>490</td><td>590</td><td>23</td><td>100</td><td>55</td><td>HRc</td></tr><tr><td>620°C±15°C 1h</td><td>440</td><td>510</td><td>25</td><td>150</td><td>HRc</td><td></td></tr></table>						Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	-20°C	-40°C	As Welded	490	590	23	100	55	HRc	620°C±15°C 1h	440	510	25	150	HRc	
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				-20°C	-40°C																								
As Welded	490	590	23	100	55	HRc																							
620°C±15°C 1h	440	510	25	150	HRc																								
REDRYING	Not required																												
GAS ACC. EN ISO 14175	M21, C1																												



CEWELD SG M0

SG M0 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405609
D-100	1	8720663405586
D-200	5	8720663405593

SG M0 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405616
D-200	5	8720663405623

SG M0 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663405630
Drum	250	8720663405647

SG M0 1,6MM

Packaging	KG/unit	EanCode
Drum	250	8720663405715