



CEWELD SACW Mo

TYPE Seamless copper coated wire Type P1

APPLICATIONS SA CW Mo is a cored wire for 0.5%Mo steels, i.e. P1. These steels are commonly used at service temperatures up to 500 °C and for some sub-zero structural applications.

PROPERTIES The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction. Typical with FL 155 Flux or FL 160

CLASSIFICATION

AWS	A 5.23: F8A4-ECA1
EN ISO	24598-A: S T Mo FB
F-nr	6
FM	4

SUITABLE FOR S355J0, E335, P285NH, P310GH, S355J0Cu, 16Mo3, P315N - S420N, P315NH - P420NH fine grain structural steels up to S460N/P460N, large-diameter pipes up to L485MB

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Mo
0.1	0.2	0.09	0.02	0.02	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	
675°C- 705°C 1h	490	570	24	120	80	HRc

REDRYING Not required

GAS ACC. EN ISO 14175