



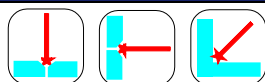
SGMo-D2

AWS A 5.28: ER80S-D2
EN ISO 636-A- W Z2Mo

DESCRIPTION

Structural steels resistant to heat and to hot work creep. Pipelines, steam boilers, pressure tanks, gas pipes, ship building sector, chemical, petrochemical sector, equipment, building of cranes.

WELDING POSITIONS



CURRENT

DC-

GAS

Ar (I1)

BASE MATERIALS

Construction steel, pressure steel

P235G1TH, P255G1TH, P310GH, 16Mo3, A255, A350, A612, A210, A333, A316, A369, A106,

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
670	550	24	70 J (-30° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	Cr	Mo	Ni	V	Cu	Zr+Ti
0,09	0,70	1,9	<0,15	0,5	<0,1	<0,02	<0,25	<0,05

PACKAGING

Dimension(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000	
Box(kg)	5	5	5	5	

EQUIVALENT FILLER METALS

MAG	Meltolit SGMo-D2
FCW	Megafil 825R, 235M