

Meltolit

SGMo

AWS A 5.28: ER70S-A1
 EN ISO 14341-A G 2Mo
 EN ISO 21952-A G MoSi

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/ Co2 (M21), Co2(C1)

BASE MATERIALS

Construction steel, pressure steel

P295GH, P355GH, 16Mo3, 17Mo3, 14Mo6, S275, S355, S420, A210, A285, A335, A516, S275MI, S355M, S420M, S460 15Mo3, 10MnMo45, 11MnMo45, GS60, GS22Mo4, 20MnMoNi5-5, 15NiCuMoNd5S, 17MnMoV64

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
610	520	25	150 J (+20° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	Cr	Mo	Ni	V	Cu
0,09	0,60	1,2	<0,15	0,5	<0,1	<0,02	<0,25

PACKAGING

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	16	5/16	5/16	16
Wire feeding/(min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	40-170	80-280	120-350	250-400
Volt (V)	16-22	18-28	20-32	28-36

EQUIVALENT FILLER METALS

TIG	Meltolit SGMo
FCW / MCW	Megafil 825R, 235M