

MIGWELD Mo

83

MIG/MAG WIRES
(GMAW)**CLASSIFICATION:**

EN ISO 14341-A: G 42 2 C1 2Mo/G 46 6 M21 2Mo
 DIN 8575: SG Mo
 AWS A-5.28: ER 80S-G (ER 70S-A1)

APPROVALS:

UDT
 TUV

DESCRIPTION:

- Solid welding wire with 0,5% Mo for MAG welding.
- Recommended for welding the creep resistant steels, working in the temperature up to 500°C.

APPLICATION:

Steam boilers, pipelines, fittings, repair of thermal energy devices

BASE MATERIAL:

| | EN |
|---------------------|-----------------------|
| Construction steels | S235-S355 |
| Boiler plates | P235GH-P355GH, 16Mo3 |
| Pipelines | P235-P355N, 16Mo3 |
| Shipbuilding plates | A, B, D, E, AH32-EH36 |
| Finegrained steels | S275-S420 |

TYPICAL CHEMICAL COMPOSITION (%):

C 0,10 Si 0,60 Mn 1,15 Mo 0,50

TYPICAL MECHANICAL PROPERTIES:

Re: >460 N/mm²
Rm: ≥560 N/mm²
A5: >22%
Kv: >47J (-20°C)

Heat treatment:

Annealing: 720°C/30 min, furnace cooling to 300°C, then in air

Shielding gases acc. to EN ISO 14175:

M21: Ar + 15-25% CO₂

| φ | Welding parameters | | | Packing |
|-----|--------------------|-------------|-----------|-----------------------|
| | Current [A] | Voltage [V] | Transfer | Weight of packet [kg] |
| 1,0 | 80-95 | 17-19 | short arc | 15,0 |
| 1,0 | 240-270 | 24-27 | spray arc | 15,0 |
| 1,2 | 110-130 | 18-20 | short arc | 15,0 |
| 1,2 | 270-320 | 27-32 | spray arc | 15,0 |

RELATED PRODUCTS: BASOWELD Mo, RUTWELD Mo

Read more about this product: <https://www.metalweld.pl/en/migweld-mo>

GMAW wires for creep resistant steels