

TIGWELD Mo

TIG Rods [GTAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 636-A : W 46 4 2Mo / EN ISO 21952-A: W MoSi DIN 8575 : SG Mo AWS A-5.28 : ER 70 S-A1/ER 80S-G	UDT, TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Welding rod with the addition of Mo for TIG welding.
- For welding creep resistant steels working under pressure.
- Weld working temperature up to 500°C.

Application

Steam boilers, pipelines, fittings. Repair of power plant machines.

Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH, 16Mo3
Pipelines:	L235-L355N, 16Mo3
Shipbuilding plates:	A, B, D, E, AH32-EH36
Finegrained steels:	S275-S420
ASTM	A182/A336 F1, A204 grades A/B/C, A209/A250 T1, A217 WC1, A335 P1, A352 LC1

Typical chemical composition %

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

Typical mechanical properties

Yield strength Re [N/mm²]	>460
Tensile strength Rm [N/mm²]	560-600
Elongation A5 [%]	>18
Impact energy Kv [J]	>47] (-40°C) /
Shielding gases acc. to EN ISO 14175	I1 - Ar /

Welding parameters and packing

∅	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0/25,0
2,0	1000 /	5,0/25,0
2,4	1000 /	5,0/25,0
3,0	1000 /	5,0/25,0