

EZ - SG Mo

CLASSIFICATION

EN ISO 14341-A	AWS / ASME SFA-5.18	DIN 8575	W. Nr.
G 46 2 M 2 Mo	ER80S-G	SG Mo	1.5424

DESCRIPTION AND APPLICATION

A copper or bronze coated solid wire alloyed with molybdenum, used for welding of mild and low-alloyed steels with tensile strength up to 590 N/mm². Application for constructions, pipes and high-pressure vessels with working range temperature up to 500°C.

Steel grade	HRN	DIN (W. Nr.)		HRN / EN / ISO
Constructional steels	Č 0361 do Č 0563	St 37-2 (1.0037) do	St 52-3N (1.0570)	S 235JR do S 355J2G3 Fe 360 B do Fe 510 D1
Boiler steels	Č 1202	Č 1204	HI (1.0345) HIII (1.0435)	P235GH P285NH
	Č 3113	Č 3105	17Mn4 (1.0481) 19Mn6 (1.0473)	P295GH P355GH
Tube and pipe steels	Č 1214	Č 1215	St 35.8 (1.0305) St 45.8 (1.0405)	P235G1TH P255G1TH
	Č 7100		15Mo3 (1.5415)	16Mo3

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (-20°C) J
> 430	540 - 640	> 20	≥ 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Si	Mn	Mo
%	0,06 - 0,1	0,4 - 0,6	1,0 - 1,15	0,45 - 0,5

SHIELDING GAS

M21

PACKAGING

Wire diameter mm	Winding
0,8; 1,0; 1,2	precision-wound (S-S)
15 kg - metal spool (S-S)	

APPROVALS

DB; TÜV

