

# CEWELD S2 Mo

|                       |   |                              |  |
|-----------------------|---|------------------------------|--|
| <b>TYPE</b>           | Solid wire for submerged arc welding with 0,5% Mo   |                              |  |
| <b>ANWENDUNGEN</b>    | Heat, creep-resistant and fine grain steel for working temperatures up to 500°C. Often used for pipe welding (X70). |                              |  |
| <b>EIGENSCHAFTEN</b>  | Copper coated SAW wire best in combination with flux FL 155   |                              |  |
| <b>KLASSIFIKATION</b> | AWS   | A 5.23: EA2                  |  |
|                       | EN ISO  | 14171-A: S2Mo, 24598-A: S Mo |  |
|                       | W.Nr.   | 1.5425                       |  |
|                       | F-nr  | 6                            |  |
|                       | FM  | 3                            |  |

**GEEIGNET FÜR**

| Materials         | DIN                         | EN                 | ASTM       |
|-------------------|-----------------------------|--------------------|------------|
| Boiler steels     | HI, HII, 17Mn4, 19Mn5,      | P235GH, P355GH,    | Typical    |
| -                 | 15Mo3, 16Mo3                | 16Mo3              | A 285Gr C  |
| Pipe steels       | St35.8, St45.8, StE 210.7TM | P235T1/T2, P460NL2 | A 515Gr 70 |
| -                 | StE 445.7 TM                | L210, L445MB       | A 516Gr 70 |
| Fine grain steels | StE 255 - StE 460           | S255 - S460QL1     | -          |

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17Mo3, 22Mo4, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV6 4 , A335 Grade P1, Boiler steels: P235GH, P310GH, ASTM A516 grade 60, Pipe steels: L320Nb, L415Nb, L360Nb, L485Nb, X52-X70 Fine-grain steels:, S460N, P255NH, P460NH, P460NL1, Cast steels: GE 240, GE 300

**ZULASSUNGEN** TÜV: (12523), CE

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)**

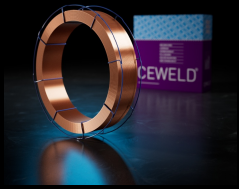
| C   | Si   | Mn  | P     | S     | Mo  |
|-----|------|-----|-------|-------|-----|
| 0.1 | 0.15 | 1.1 | 0.015 | 0.015 | 0.5 |

**MECHANISCHE GÜTEWERTE**

| Heat Treatment | R <sub>PO,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |       | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|-------|-------|----------|
|                |                         |                      |                    | RT                      | -20°C | -40°C |          |
| As Welded      | 520                     | 600                  | 25                 | 100                     | 90    | 50    | HRc      |
| 580°C±15°C 2h  | 500                     | 610                  | 25                 | 60                      | 50    | HRc   |          |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175**



# CEWELD S2 Mo

## S2 MO 2,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 300     | 8720663404633 |
| K-415     | 25      | 8720663404695 |

## S2 MO 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 300     | 8720663404626 |
| K-415     | 27      | 8720663424211 |

## S2 MO 3,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 27      | 8720663404664 |

## S2 MO 4,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 370     | 8720663404640 |
| K-415     | 25      | 8720663404688 |