



# CEWELD SG Mo Tig

| TYPE                                                 | Fil de soudure cuivré pour les aciers 0,5% Mo.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|-----------------------|-------------------------|-------|----------|--|----------------|----------------------------|-------------------------|-----------------------|-------------------------|-----|----------|-------|-------|-----------|-----|-----|----|-----|----|-----|---------------|-----|-----|----|-----|-----|--|
| APPLICATIONS                                         | Aciers résistant au fluage, tubes à vapeur, cuves, chaudières, appareils, etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| PROPRIÉTÉS                                           | Excellentes propriétés de soudage et résistance mécanique jusqu'à 460 MPa de limite d'élasticité.<br>Excellent pour une utilisation résistant au fluage à des températures allant jusqu'à 500 °C.                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.28: ER 70S-A1, A 5.28: ER 80S-G |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 636-A: W 46 4 2Mo, 21952-A: W MoSi  |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 1.5424                              |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                                   |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 1                                   |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| CONVIENT POUR                                        | <b>Typ 0,5Mo ≤ 460 MPa, ISO 15608: 1.2, 1.3</b><br>1.5415, 1.0481, 1.0482<br><b>15Mo3, 16Mo3</b> , 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300<br>ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013;<br>API 5 L B, X42, X52, X60, X65 |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| POSITIONS DE SOUDAGE                                 | <div></div>                                                       |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | <table><tr><td>C</td><td>Si</td><td>Mn</td><td>Mo</td></tr><tr><td>0.09</td><td>0.6</td><td>1.2</td><td>0.5</td></tr></table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                     |                       |                         |       |          |  | C              | Si                         | Mn                      | Mo                    | 0.09                    | 0.6 | 1.2      | 0.5   |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| C                                                    | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Mn                                  | Mo                    |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| 0.09                                                 | 0.6                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 1.2                                 | 0.5                   |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| PROPRIÉTÉS MÉCANIQUES                                | <table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R<sub>P0,2</sub><br/>(MPa)</th><th rowspan="2">R<sub>m</sub><br/>(MPa)</th><th rowspan="2">A<sub>5</sub><br/>(%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>-20°C</th><th>-40°C</th></tr><tr><td>As Welded</td><td>480</td><td>580</td><td>22</td><td>180</td><td>55</td><td>HRc</td></tr><tr><td>620°C±15°C 1h</td><td>400</td><td>510</td><td>25</td><td>200</td><td>HRc</td><td></td></tr></table>                                                                                                                                                     |                                     |                       |                         |       |          |  | Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |     | Hardness | -20°C | -40°C | As Welded | 480 | 580 | 22 | 180 | 55 | HRc | 620°C±15°C 1h | 400 | 510 | 25 | 200 | HRc |  |
| Heat Treatment                                       | R <sub>P0,2</sub><br>(MPa)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | R <sub>m</sub><br>(MPa)             | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |       | Hardness |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                     |                       | -20°C                   | -40°C |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| As Welded                                            | 480                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 580                                 | 22                    | 180                     | 55    | HRc      |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| 620°C±15°C 1h                                        | 400                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 510                                 | 25                    | 200                     | HRc   |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| ETUVAGE                                              | Non requis                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                     |                       |                         |       |          |  |                |                            |                         |                       |                         |     |          |       |       |           |     |     |    |     |    |     |               |     |     |    |     |     |  |



# CEWELD SG Mo Tig

|                        |           |         |               |
|------------------------|-----------|---------|---------------|
| SG MO TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                        | Tube      | 5       | 8720663411341 |
| SG MO TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                        | Tube      | 5       | 8720663411358 |
| SG MO TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                        | Tube      | 5       | 8720663411365 |
| SG MO TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                        | Tube      | 5       | 8720663411372 |
| SG MO TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                        | Tube      | 5       | 8720663411389 |