

# TIG welding rods for mild and low alloyed steel

WSG Mo			
Classification DIN EN ISO		Classification AWS	
636-A W 46 4 W2Mo, 21952-A WMoSi		A5.28 ER70S-A1, A5.28 ER80S-G	
Approvals		Material No.	
TÜV 03466.07, CE, DB 42.045.08		1.5424	
Characteristics and application			
TIG/GTAW rod for 0.5%Mo steels. These steels are commonly used at service temperatures up to 500°C and for some sub-zero structural applications. The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction. The good general mechanical properties also ensures use in general structural engineering applications.			
Base materials			
For similar alloyed high temperature steels and cast steels, ageing resistant and steels resistant to caustic cracking. P235G1TH-P255G1TH, P310GH, L320, L360NB-L415NB, 16Mo3 ASTM: A182/A336 F1, A204 grades A/B/C, A209/A250 T1, A217 WC1, A335 P1, A352 LC1			
Typical analysis in %			
C	Si	Mn	Mo
0,10	0,60	1,15	0,52
Typical heat treatment			
Preheat temperature: Dependent on material thickness Interpass temperature: max. 250°C PWHT: AW or 650°C			
Mechanical properties of the pure weld metal			
Yield strength in Mpa	Tensile strength in Mpa	Elongation in %	Charpy-V-Value (ISO-V) in J
≥ 460	≥ 560	4d/5d: ≥ 22	RT ≥ 60 -40°C ≥ 47