

UNISCO 70S-A1 MIG/TIG

Specification

EN 440	G2Mo
EN 1668	W2Mo
EN 12070	G MoSi / W MoSi
Steel no.	1.5424
AWS/SFA 5.28	ER70S-A1

Typical chemical composition of wire

<u>C</u>	<u>Si</u>	<u>Mn</u>	<u>Mo</u>
0,10	0,60	1,15	0,52 %

Description

SG Mo is designed to be used for welding 0,50 % Mo steels used for creep resisting service at temperatures up to about 500 degrees celsius.

Material to be welded

P235G1TH – P255G1TH, P310GH,
16Mo3, L320,
L360NB – L415NB,
WIG also 15 NiCuMoNb 5 (WB 36)

Typical mechanical properties of weld metal

Yield point (R_e)	≥ 460 N/mm ²
Tensile strength (R_m)	≥ 560 N/mm ²
Elongation (A) ($L_o = 5 d_o$)	≥ 22 %
Impact value (A_v) (ISO-V)	
MIG -20 °C	≥ 47 J
TIG -20 °C	≥ 47 J