

# CEWELD S2 Mo

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

**SUITABLE FOR**

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

**APPROVALS** TÜV: 12523, CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

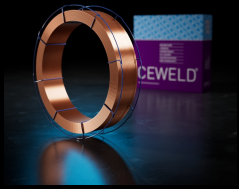
C	Si	Mn	P	S	Mo
0.1	0.15	1.1	0.015	0.015	0.5

**MECHANICAL PROPERTIES**

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	

**REDRYING** 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