



# SGMo-D2

AWS A 5.28: ER80S-D2  
EN ISO 14341-A G 50 2 M21 4Mo

## DESCRIPTION

Structural steels resistant to heat and to hot work creep. Pipelines, steam boilers, pressure tanks, gas pipes, ship building sector, chemical, petrochemical sector, equipment, building of cranes.

### WELDING POSITIONS



### CURRENT

DC+

### GAS

Ar/ Co2 (M21), Co2(C1)

## BASE MATERIALS

Construction steel, pressure steel

P295GH, P355GH, 16Mo3, 17Mo3, 14Mo6, S275, S355, S420, A210, A285, A335, A516, S275MI, S355M, S420M, S460 15Mo3, 10MnMo45, 11MnMo45, GS60, GS22Mo4, 20MnMoNi5-5, 15NiCuMoNd5S, 17MnMoV64

## MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A<sub>5</sub></i> (%)	<i>KV(j)</i>
610	520	25	150 J (+20° C)

## WELD METAL COMPOSITION(%)

C	Si	Mn	Cr	Mo	Ni	V	Cu
0,09	0,60	1,2	<0,15	0,5	<0,1	<0,02	<0,25

## PACKAGING

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	16	5/16	5/16	16
Wire feeding/(min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	40-170	80-280	120-350	250-400
Volt (V)	16-22	18-28	20-32	28-36

## EQUIVALENT FILLER METALS

TIG	Meltolit SGMo-D2
FCW / MCW	Megafil 825R, 235M