

Meltolit

SGMo E

AWS A5.5: E7018-A1 ISO 3580-A: E Mo B42 H5
Material group: FM3

DESCRIPTION

Low hydrogen basic coated electrode alloyed with Mo for welding creep resistant steels used at temperatures up to 500°C. Good resistance to hydrogen attacks (chemical installations). For piping systems, boilers, overheaters. Soft fusion, good slag removal, nice aspect of the weld bead.

WELDING POSITIONS



POLARITY

DC+

COATING

Basic

MATERIAL

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 ANALYSIS

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	A5 (%)	KV(j)
>550	>450	>22	+20°C >100

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Mo
<0.10	0,8	0,4	-	0,5

PACKING INFORMATION AND WELDING CURRENT

Dimension	2,5 x 350	3,2 x 350	4,0 x 450	5,0 x 450
Kg/pack	5	5	6	6
Ampere(A)	80	115	150	190

EQUIVALENT CONSUMABLES

TIG	Meltolit SGMo Tig
MAG	Meltolit SGMo Mag
FCW	Megafil 235M, 825R

Re-drying if necessary for two hours in 350°C. Interpass temperature: 100-250°C
Annealing after welding is advised at 650°C/1h