

CARBO S- Mo

CARBO T- Mo

International standards

	S = solid wire	T = bare rod
Material No.	1.5424	
EN ISO 21952-A	G MoSi	W MoSi
EN ISO 636-A		W2Mo
AWS SFA-5.28	ER 80 S-G	ER 80 S-G

Approvals

Application notes

Low alloyed moly containing steel MIG/TIG wire for welding heat resistant steels for working temperatures up to 550°C.
Preheating temperatures depend on the base material.

Operating temperature

20° C up to + 550° C

Base materials

St 35.8, St 45.8, P235, S235, P460, S460
HI, HII, 17 Mn 14, 19Mn6 ,15Mo3, 16Mo3, G20Mo5
GS-C25, GS-22 Mo 4
WStE 255 up to WStE 460
TÜV-Kennblatt 1000: Gruppe 1-5 und 8-10
ISO 20172: Gruppe 1.2 / 1.3 (ReH max 460N/mm²)
ISO 20172: Gruppe 2.1
ISO 20172: Gruppe 3.1 (ReH max 460N/mm²)

Mechanical properties of all-weld-metal with Gas: M 21 (typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at	
			-20°C	-40° C
610	500	24	100	57

Weld metal analysis (typical, wt %)

C	Si	Mn	Mo
0,10	0,6	1,1	0,5

Gas types EN 439

S = solid wire
M1, M2, M3, C1

T = bare rod
I1

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

B300 15 kg.

25 kg.

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