



HILCO FER SGMo

TIG rods – low alloyed steel – creep resisting

AWS A5.28: ER 70S-A1
EN ISO 636-A: W 46 4 2Mo
EN ISO 21952-A: W MoSi

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:
I1

Fer SGMo is our solid wire for TIG welding low alloyed fine grain and creep resisting steels like 16Mo3 up to a maximum operating temperature of 500°C. Typical applications include the construction of pressure vessels, boilers and pipes. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- Boiler steel P235GH-P310GH, 16Mo3, 17Mo3, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV64, A355 Grade P1
- Fine grain steel S275N-S500N, P355NH-P460NH, S355NL-S500NL
- Pipe steel L320NB-L415NB, L360MB-L415MB
API 5L X52-X70

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Mo
0,10	1,15	0,60	0,52

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 460	≥ 560	≥ 22	20°C ≥ 60 -40°C ≥ 47

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
2,4	1000	5