



AWS A5.28: ER80S-D2
 BS 2901 Pt1: A31 (Obs.)
 BS EN 440 1994 G4Mo

TIG/MIG Filler Wire

MnMo Steels

CMW-1910

DESCRIPTION & APPLICATION

TIG/MIG Filler Wire for the joining or overlay of Creep resistant Manganese Moly steels operating at elevated temperature (~500°C). Typical applications include the welding of pressure vessels and assorted pipe-work, and the joining of high-strength steels.

BASE MATERIALS

BS EN 10028-2- 15Mo3,16Mo3, Werkstoffe No 1.5415
 BS 970 Pt 3 605/606M36,
 BS 1501-2 Grade 243B

MECHANICAL PROPERTIES

670 UTS n/mm	560 YIELD 0.2%	~22 ELONG A5%	~50 CHARPY (J)-20°C
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METAL WELD COMPOSITION %

C	Si	Mn	S	P	Mo	Fe
0.1	0.75	1.8	0.02	0.02	0.5	BAL

PACKAGING

15kg Spools (MIG)
 5kg Tubes (TIG)

DIAMETERS

1.6, 2.4, 3.2mm (TIG)
 0.8, 1.0, 1.2mm (MIG)

WELDING INSTRUCTIONS

Preheat as per the requirements of the base material. For welding high strength steels, PWHT or controlled cooling, may be required to maintain mechanical values.