



WELDING

UP S2Mo

Classification

AWS A5.23 : EA2
ISO 14171-A S2Mo

ISO 24598-A : S S Mo

Description & Applications

Copper coated solid wire for submerged arc welding 0.5%Mo high strength steels. Used at service temperature up to 500°C. Creep resistance improved with Mo alloying compared to C-Mn wire.

Main applications: Steel constructions, pressure vessels, tanks...

Base material:

Fine grain steels, pipes steels, heat resistant steels

EN / ISO	ASTM	API-5
P420N / S420NL	A633 gr.E	X60 to X70
P460N / S460NL	A204 gr.A	
L415N to L485Q	A209 gr. T1	
S275J2G3	A572 gr. 42	
S355J2G3	A572 gr. 50	
16Mo3		

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Al	V	P	S	Fe
Min	0.08	0.05	0.80			0.45							
Max	0.12	0.25	1.20	0.15	0.15	0.65	0.30	0.01	0.030	0.03	0.025	0.025	Rem.
Type	0.09	0.16	1.15	0.02	0.01	0.50	0.07	0.005	0.005	0.04	0.006	0.005	Rem.

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW AC	2.4	360 - 450	25 - 30	18	40 - 60	UP LA01
	3.2	400 - 500	28 - 32	20	40 - 60	UP LA04
	4.0	500 - 600	30 - 35	22	50 - 60	UP LA05 UP BF10

Interpass temperature: <200°C.

FT En-SF11-161213

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