

DATA SHEET

SW 80S Mo 15kg/Spule 1.2mm

097-003547-30012

- Low-alloy solid wire electrode, creep-resistant
- Copper-plated, layer wound
- Low-spatter thanks to high chemical purity
- Mainly for welding creep-resistant 0.5% Mo steels
- Maximum operating temperature 500 °C
- **Fields of application:**
 - Boiler, container, pressure vessel and pipeline construction



Standards	DIN EN ISO 14341-A - G46 6 M21 2 Mo AWS A-5.28 - ER 80S-G			
Material number	1.5424			
Welding positions	PA / PB / PC / PD / PE / PF			
Polarity	DC+			
Ø	1.2 mm			
Chemical analysis (in %)	C	Si	Mn	Mo
	0.1 %	0.6 %	1.15 %	0.52 %
Shielding gas	M21			
Yield strength	≥460 MPa			
Tensile strength, Rm	≥560 MPa			
Expansion, A5	≥22 %			
Impact energy, Av	20 °C: ≥ 100 J -40 °C: ≥ 47 J			
Approvals	CE / TÜV / DB			
Packing drum	B300			
Weight	15 kg			
Base materials	Similarly alloyed creep-resistant steels and cast steel			

S355 | P235G1TH - P255G1TH | P310GH | L320 | L360NB - L415NB | 16Mo3

ASTM: A182/A336 grade F1 | A204 grades A/B/C | A209/A250 grade T1 | A217 grade WC1 | A335 grade P1 |
A352 grade LC